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Buecker

(54) CHEET METAL BEAM

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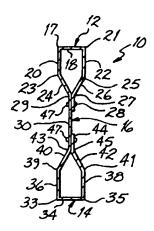
[57] ABSTRACT

A building beam structure having two sheet metal chords and a sheet metal central web section disposed between the two chords. Each chord has an end wall with two opposed side walls extending therefrom and two angular support walls extending from the side walls. The angular support walls converge inwardly from the side walls toward the central web section. The central web section has a main web wall extending between one of the angular support walls on each of the chords. In addition, the central web section has a first web wall section extending from another of the angular support walls on one of the chords, and a second web wall section extending from another of the angular support walls on another of the chords.

28 Claims, 4 Drawing Sheets

[54]	SHEET N	IETA.	L BEAM
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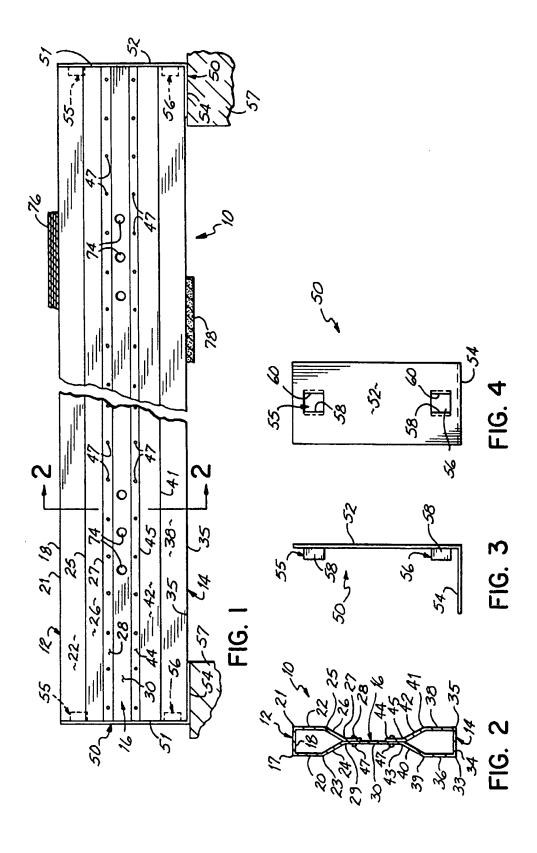
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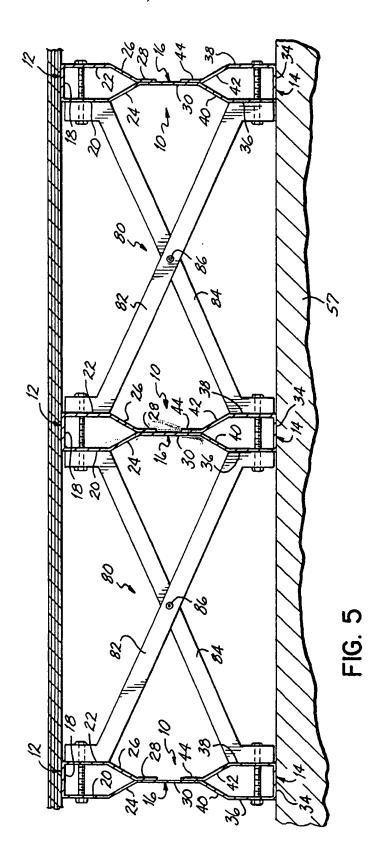


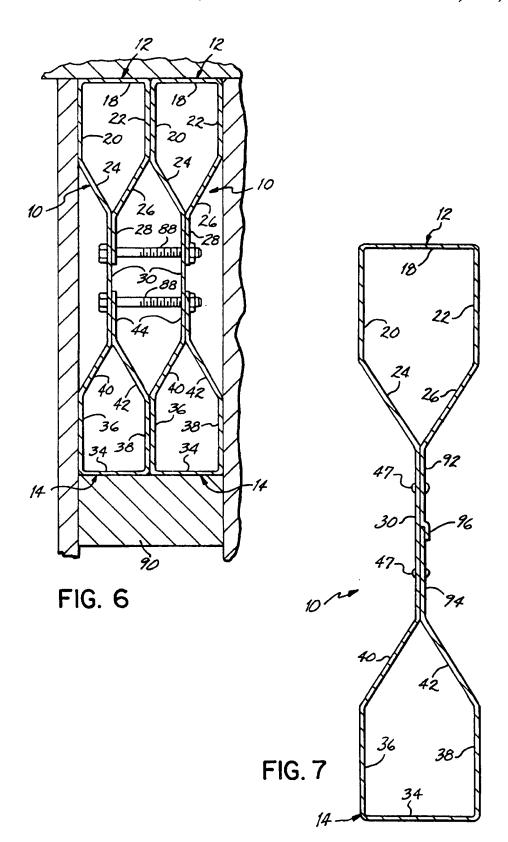
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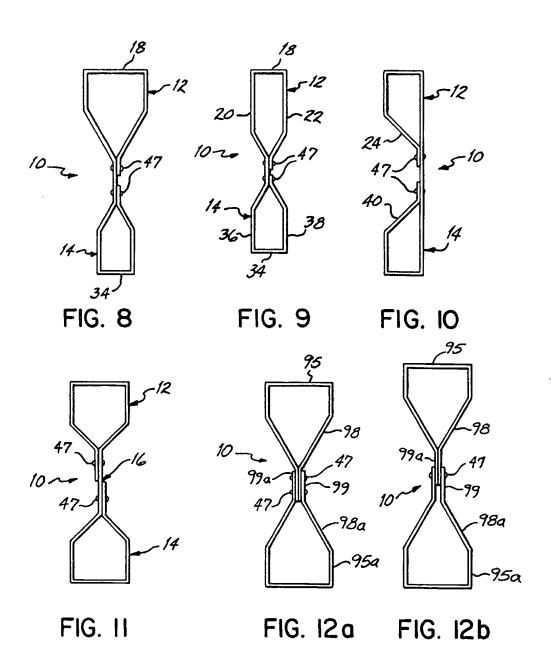
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SHEET METAL BEAM

CROSS REFERENCE TO RELATED APPLICATIONS

This application is a continuation application corresponding to provisional application Ser. No. 60/073,871, entitled "Sheet Metal Beam", filed on Feb. 4, 1998.

BACKGROUND OF THE INVENTION

This invention relates to construction materials and more particularly, to a new structural member.

Over the years, there have been several attempts to develop alternative construction materials to wood joists, rafters and studs. Even though the problems associated with wood, as a raw material, continue to increase in residential construction, wood remains the dominant structural material.

As world population and economic development increase, the demand for wood also increases, thereby placing significant pressures on our natural resources and other supplies of wood stock. The net result is a general increase in the price of wood. In addition, wood stock, as with other resources, experiences spot variations in price as a function of spot shortages caused by weather, transportation prob- 25 lems and other variables. Further, over the last several decades, the overall quality of wood stock has generally declined. The quality and price issues are even more dramatic for wood joists, that is, the structural members that extend horizontally between vertical walls and provide a subjacent for a floor or roof above the joist. Joist members are generally nominally, 2 inches thick, are nominally in a range of from six inches to 12 inches wide and are most often, ten feet and more in length. Thus, as the wood resource becomes more scarce, of generally lower quality and more expensive, larger wood structures, such as joists, which require high quality wood to provide the desired straightness over their lengths, are proportionally even more

In use, often to reduce costs, longer joists, for example, those over twelve feet, are fabricated from shorter pieces which are spliced together. Further, as with all wood products, wood joists are subject to damage from termites and other insects.

Several alternatives to the standard wood joist have been considered. For example, fabricated wood I-beams are commercially available from Trus Joist Corporation of Boise, Id. While such fabricated I-beams have the advantage of being manufactured to any length and having a predictable quality, such fabrications are relatively expensive.

Structural members made of steel are widely used in commercial office construction and are now beginning to be used in residential construction. Typically, steel structural members are used for wall studs to which a wall material, for example, wallboard, is attached. Rafters and ceiling joists are frequently integrated into a truss assembly. Such structural steel products are available from Clark-Cincinnati Steel Framing Systems of Cincinnati, Ohio.

A hybrid metal and wood I-beam structure is commercially available from Light Beam Inc. of Santa Monica, Calif. In this beam structure, a pair of sheet metal plates are clinched together to form an I-beam web section and wood members, for example, nominal 2x4 wood pieces, are attached to the web and form the top and bottom cords or 65 flanges of the I-beam. Such a beam structure is fabricated from two identical sheet metal pieces which are attached

2

with nails or other fasteners to the wood flanges. That structure again has some of the inherent disadvantages of an all wood beam, and has the further disadvantage of a relatively high cost to fabricate the hybrid sheet metal and wood structure.

Further, U.S. Pat. Nos. 3,342,007 and 2,049,926 illustrate different designs for a steel joist. However, in spite of the above, the use of substitutes for a standard wood joist in residential construction has been limited.

Consequently, there is a need for a substitute for the standard wood joist that does not have the limitations and disadvantages of known substitutes and provides a practical, higher quality joist structure for less cost.

SUMMARY OF THE INVENTION

The present invention provides a sheet metal joist that is less expensive, stronger, lighter and easier to use than the traditional wood joist. Further, the sheet metal joist of the present invention can be readily manufactured to any length and provided to a contractor without warpage or twisting. The sheet metal joist of the present invention is long-lasting and not susceptible to termite damage and an effective substitute for a traditional wood joist. The sheet metal joist of the present invention includes attachment walls that provide flat, vertical surfaces to which drywall and other building components may be easily attached using known fasteners. Further, the double-wall web construction of the present invention increases the material in the web plane between the top and bottom load bearing rails, thereby substantially strengthening the joist.

In accordance with the principles of the present invention and in accordance with one embodiment, the present invention provides a building beam structure having two sheet metal rails and a sheet metal central web section disposed between the two rails. Each rail has an end wall with two opposed side walls extending therefrom and two angular support walls extending from the side walls. the angular support walls converge inwardly from the side walls toward the central web section. The central web section has a main web wall extending between one of the angular support walls on each of the rails. In addition, the central web section has a first web wall section extending from another of the angular support walls on one of the rails, and a second web wall section extending from another of the angular support walls on another of the rails.

In one aspect of the invention, the side walls and central web section are substantially perpendicular to the end walls of the rails. In another aspect of the invention, one of the end walls is adapted to receive a load and the other of the end walls is adapted to rest on a surface, thereby supporting the beam and the load. In a further aspect of the invention, the rails and the central web section are made from a single piece of sheet metal.

These and other objects and advantages of the present invention will become more readily apparent during the following detailed description taken in conjunction with the drawings herein.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a side elevation view of the sheet metal beam in accordance with the principles of the present invention.

FIG. 2 is a cross-sectional view taken along line 2—2 of FIG. 1.

FIG. 3 is a an end view of an end piece to be used with the sheet metal beam.

FIG. 4 is a front elevation view of the end piece of FIG. 3.

FIG. 5 is a partial cross-sectional view of bridging used with sheet metal joists of the present invention.

FIG. 6 is a cross-sectional view of the sheet metal joists ⁵ being used as a lintel.

FIGS. 7-12 are cross-sectional views of alternative embodiments of the sheet metal joist in accordance with the principles of the present invention.

DETAILED DESCRIPTION OF THE INVENTION

FIGS. 1 and 2 illustrate a sheet metal joist 10 having a first, upper chord or rail 12 and a second, lower chord or rail 14. The chords 12, 14 are joined by a connecting intermediate web section 16. One of the chords, 12, 14 and a connecting portion of the web section 16 may also be considered a beam component. The top chord 12 is shaped to form a polygon, and more specifically, a pentagon. The 20 top chord 12 has a normally horizontal load-bearing upper surface or end wall 18 that extends longitudinally over the full length of the joist 10. The load-bearing surface 18 has longitudinally extending opposed lateral edges that are contiguous with, and intersect, longitudinally extending upper 25 edges of respective opposed side walls 20, 22 to form respective corners 17, 19. The two side or fastening walls 20, 22 are generally parallel and generally perpendicular to the load-bearing surface 18 and are normally oriented in the generally vertical direction. The fastening or side walls 20, 30 22 provide flat fastening surfaces to which materials may be connected in the normal course of construction. The fastening walls 20, 22 having longitudinally extending lower edges that are contiguous with, and intersect, longitudinally 24, 26 to form respective corners 23, 25. The support walls 24, 26 converge inwardly toward the centrally located web section 16. The angular support wall 24 has a longitudinally extending lower edge that is contiguous with, and intersects, a longitudinally upper edge of a main web wall 30 to form 40 a bend or corner 29. The angular support wall 26 has a longitudinally extending lower edge that intersects and is contiguous with a longitudinally upper edge of a first web wall section 28 to form a bend or corner 27.

The bottom chord 14 is generally the same shape and 45 normally the same size as the top chord 12. The bottom chord 14 has a normally horizontal lower surface or end wall 34 generally parallel with the opposing end wall 18. The end wall 34 has longitudinally extending opposed lateral edges that are contiguous with, and intersect, longitudinally 50 extending lower edges of opposed respective side walls 36, 38 to form respective corners 33, 35. The fastening or side walls 36, 38 are generally parallel and generally perpendicular to the end wall 34, are normally vertical and provide further flat, fastening surfaces. The fastening walls 36, 38 55 have longitudinally extending upper edges that are contiguous with and intersect longitudinally extending lower edges of respective angular support walls 40, 42 to form respective bends or corners 39, 41. The angular support walls 24, 26 converge inwardly toward the centrally located web section 60 16. The angular support wall 40 has a longitudinally extending upper edge that is contiguous with and intersects a longitudinally extending lower edge of the main web wall 30 to form a bend or corner 43. The angular support wall 42 has a longitudinally extending upper edge that is contiguous 65 with and intersects a longitudinally extending lower edge of a second web wall section 44 to form a bend or corner 45.

4

The web wall sections 28, 44 are rigidly connected to the main web wall 30 using known fastening devices 47, for example, rivets, TOG-L-LOCK fasteners, sheet metal screws, bolts, etc. Alternatively, the web wall sections 28, 30, 44 are connected by fastening devices such as adhesives, spot welding, seam welding, and other joining mechanisms known in the art. The application of the fastening devices adds substantial strength and rigidity to the beam structure especially in a direction parallel to a plane of the intermediate web section 16 which is normally the vertical direction. The sheet metal joist of FIGS. 1 and 2 is normally formed by rolling a continuous piece of the sheet metal stock over a plurality of dies. While preferably the joist is made from approximately 20-gauge thick sheet metal, the sheet metal thickness may vary in the range of from approximately 16-gauge to approximately 24-gauge, depending upon the application and the capacity of the roll-forming machine. The heights of the fastening surfaces 20, 22, 36, 38 and the height of the web wall 30 may be varied to vary the nominal size of the joist, for example, from a 2×8 joist to a 2×12 joist. The joists are cut to their desired nominal lengths either before or after the fabrication process.

FIGS. 3 and 4 illustrate an end plate 50 which may be used to terminate the ends 51 of joist 10. The end plate is preferably L-shaped with a generally vertical nailing plate 52 that intersects a generally horizontal locating plate 54. As will be appreciated, the plate 54 is optional depending on the application. The nailing plate 52 has centrally located upper and lower flange pairs 55, 56, respectively. Each flange pair has opposed flanges 58, 60 which are separated to fit adjacent to the fastening walls 20, 22, 36, 38 within the cavities bounded by the walls of the top and bottom chords 12, 14.

edges that are contiguous with, and intersect, longitudinally extending upper edges of respective angular support walls 24, 26 to form respective corners 23, 25. The support walls 24, 26 converge inwardly toward the centrally located web section 16. The angular support wall 24 has a longitudinally extending lower edge that is contiguous with, and intersects, a longitudinally upper edge of a main web wall 30 to form a bend or corner 29. The angular support wall 26 has a longitudinally extending lower edge that intersects and is contiguous with a longitudinally upper edge of a first web wall section 28 to form a bend or corner 27.

The bottom chord 14 is generally the same shape and normally the same size as the top chord 12. The bottom

Sub-flooring 76 is attached to the upper load-bearing surfaces of end walls 18 by known fasteners, and drywall or other ceiling material 78 is attached to the lower surfaces 34 by known means. After the joist is secured in place, plumbing and electrical utilities are then installed. The joist 10 is normally manufactured with holes 74 that extend through the web section 16; and the holes 74 are sized to receive pipes and/or wires, thereby facilitating the installation of the plumbing and electric utilities. The holes 74 may be made as part of the joist fabrication or made on-site in the field.

As illustrated in FIG. 5, bridging 80 may be installed between the joists 10. Bridging is normally fabricated to provide an X-shaped structure having two legs 82, 84. Leg 82 has one end connected to the top chord 12 of a first joist and has the opposite end connected to a bottom chord 14 of an adjacent joist. The leg 84 is connected at one end to the bottom chord 14 of the first joist and is connected at its opposite end to the top chord 12 of the adjacent joist. For increased strength, the bridging legs 82, 84 are connected together with a fastener 86. In a totally metal construction, the bridging legs 82, 84 may be formed from metal tubing

that is 16-gauge and nominally 0.625 inch or 0.75 inch across. Either square or round tubing may be used. While two bridging legs 82, 84 are illustrated in FIG. 5, bridging with a single leg will provide more strength than no bridging, but provides less strength than the full cross-bridging illustrated in FIG. 5. The bridging legs 82, 84 may also be made from materials other than metal, for example, wood

While the sheet metal joists may be used to support floors and ceilings as illustrated in FIG. 1, they may also be used 10 to provide a header or lintel above a window or door. As illustrated in FIG. 6, two sheet metal joists 10 are connected together by fasteners 88 extending it through the web walls 30 of the joists 10. The joists 10 are located immediately above a window frame section 90 and function to support the 15 structure located above the window or door.

FIG. 7 illustrates an alternative embodiment of the joist 10 with respect to the web wall 16. The web wall 16 contains a continuous web wall portion 30 as described with respect to FIG. 2. However, the angular support walls 26, 42 intersect web wall portions 92, 94 that extend over the full length of the web wall 30, and in addition, have an overlapping portion 96. In the alternative embodiment, the web wall portions 30, 92, and 94 are joined together by fasteners 47 as previously described with respect to FIG. 1. Depending on the length of the overlapping section 96, fasteners may be applied through the section 96. Alternatively, the section 96 may be welded or not connected at all.

The sheet metal joist heretofore described provides a substitute for a traditional wood joist that is stronger, lighter, competitively prices and easier to use than the traditional wood joist. Further, the sheet metal joist can be readily manufactured to any length and provided to the contractor without warpage or twisting. In addition, the sheet metal joists are long-lasting and not susceptible to termite damage.

The sheet metal joist includes attachment side walls 20, 22, 36, 38 that provide flat, vertical surfaces to which drywall and other building components may be easily attached using known fasteners. Further, the double-wall construction of the web 16 increases the material in the plane between the top and bottom chords, thereby substantially strengthening the joist.

While the invention has been illustrated by the description of one embodiment and while the embodiment has been described in considerable detail, there is no intention to restrict nor in any way limit the scope of the appended claims to such detail. Additional advantages and modifications will readily appear to those who are skilled in the art. For example, the sheet metal joists can be designed to have different strengths by using different carbon steel sheet metals or an alloy, as well as varying the gauge of the sheet metal

Further, the basic configuration of the building sheet metal beam structure can be modified as illustrated in FIGS. 55 8-12 for different applications and/or to satisfy different manufacturing requirements and specifications. For example, as shown in FIG. 8, the widths of the end walls 18, 34 of the respective upper and lower chords 12, 14 can be different; and as shown in FIG. 9, the height of the side walls 20, 22 of the upper chord 12 can be substantially different from the height of the side walls 36, 38 of the lower chord 14. FIGS. 8 and 9 further demonstrate that the ratio of the width of the chord to its height can be varied to suit a particular application.

FIG. 10 is a further embodiment in which only one angular support wall 24, 40 is used with each of the

respective upper and lower chords 12 and 14. FIG. 11 illustrates another embodiment of the beam in which the upper and lower chords 12, 14 are folded in the same direction, for example, counterclockwise, from the central web section 16. In contrast with the other embodiments, the upper and lower chords fold in opposite directions. For example, referring to FIG. 8, in moving from the web section, the upper chord 12 folds in a clockwise direction; and the lower chord 14 folds in a counterclockwise direction.

FIGS. 12a and 12b illustrate an embodiment in which the beam structure is made from two beam components 95, 95a. Each component has a chord section 98, 98a and a web wall section 99, 99a. The beam components 95, 95a are positioned with respect to each other such that the web wall sections overlap, and the overlapping web wall sections are joined by the fastening devices 47, for example, rivets, bolts, spot welds, electric welds, adhesives, etc. As shown in FIG. 12b, the components 95, 95a can be connected together at different relative positions, thereby permitting the beam 10 to be fabricated to different nominal heights. Further, if there is some variation in the manufacture of the components 95, 95a, the components can be fixtured and fastened together to achieve a beam having a highly uniform height over its length. In addition, as will be appreciated, the pairs of web wall sections may be of different lengths, so that a shorter web wall section of each component is joined to longer web wall sections of the two components.

While the normal application of the sheet metal beam of the present invention is intended to be in residential building construction, the sheet metal beam can be used in garages and other utility buildings, in commercial buildings, in barns, sheds and other farm buildings, landscaping structures, in bridges, as concrete reinforcement in roads and other infrastructure construction.

Therefore, the invention in its broadest aspects is not limited to the specific details shown and described. Consequently, departures may be made from the details described herein without departing from the spirit and scope of the claims which follow.

What is claimed is:

1. A building beam structure comprising:

two sheet metal chords, each of the chords having

a flat end wall,

two opposed side walls extending from the end wall and having respective flat fastening surfaces to which materials may be connected, and

two angular support walls, each of the angular support walls extending from one of the side walls, and the angular support walls converging inwardly from the side walls; and

- a sheet metal central web section disposed between the two chords and including
 - a planar main web wall extending straight between one of the angular support walls on each of the chords,
 - a first web wall section extending from another of the angular support walls on one of the chords, and
 - a second web wall section extending from another of the angular support walls on another of the chords.
- 2. A building beam structure of claim 1 further comprising fastening devices connecting the first and second web wall sections with the main web wall.
- 3. A building beam structure of claim 1 wherein the two sheet metal chords and the sheet metal central web section are made from a single piece of sheet metal.
- 4. A building beam structure of claim 1 wherein the two sheet metal chords and sheet metal central web section are

made from a single piece of sheet metal having a thickness in the range of from approximately 16-gauge to approximately 24-gauge.

5. A building beam structure of claim 1 wherein the two sheet metal chords and sheet metal central web section are 5 made from a single piece of approximately 20 gage sheet metal.

- 6. A building beam structure of claim 1 wherein the end wall of one chord is substantially parallel to the end wall of the other chord.
- 7. A building beam structure of claim 1 wherein the side walls are substantially perpendicular to each end wall.
- 8. A building beam structure of claim 1 wherein the central web section is substantially perpendicular to each end wall and substantially parallel to the side walls.
- 9. A building beam structure of claim 1 wherein each end 15 wall is disposed in a generally horizontal direction and the central web section is disposed in a generally vertical direction.

10. A building beam structure of claim 1 wherein each end wall on each of the chords has two opposed longitudinal 20 lateral edges.

11. A building beam structure of claim 10 wherein each of the two side walls on each of the chords has first and second longitudinal edges with the first longitudinal edge of each of the side walls being connected to one of the longitudinal 25 lateral edges of one of the end walls.

12. A building beam structure of claim 11 wherein each of the two angular support walls on each of the chords has first and second longitudinal edges with the first longitudinal edge of each of the angular support walls being connected to the second longitudinal edge of one of the side walls.

13. A building beam structure of claim 12 wherein the main web wall of the central web section further comprises two longitudinal edges with one of the longitudinal edges being connected to the second longitudinal edge of one of the angular support walls on one of the chords and the other of the longitudinal edges being connected to the second longitudinal edge of one of the angular support walls on the other of the chords.

14. A building beam structure of claim 13 wherein the first web wall section of the central web section further comprises a longitudinal edge connected to the second longitudinal edge of the other of the angular support walls on one of the chords.

15. A building beam structure of claim 14 wherein the second web wall section of the central web section further comprises a longitudinal edge connected to the second longitudinal edge of the other of the angular support walls on the other of the chords.

16. A building beam structure of claim 1 further comprising a plurality of holes spaced longitudinally along the central web section and sized to receive apparatus for utilities.

17. A building beam structure of claim 1 wherein one of the side walls of one chord is coplanar with one of the side walls of the other chord, and the other of the side walls of the one chord is coplanar with the other of the side walls of the other chord.

18. A building beam structure comprising:

upper and lower sheet metal chords, each of the chords having

a flat end wall,

two opposed side walls extending from the end wall and having respective flat fastening surfaces to which materials may be connected, and

two angular support walls, each of the angular support walls extending from one of the side walls, and the 65 angular support walls converging inwardly from the side walls;

8

sheet metal planar web walls extending from the angular support walls intermediate the tipper and lower chords; and

fastening devices connecting the web walls together, thereby providing a sheet metal beam structure having upper and lower chords and an intermediate web.

19. A building beam structure of claim 18 wherein the web walls further comprise

- a main web wall extending between one of the angular support walls on each of the upper and lower chords,
- a first web wall section extending from another of the angular support walls on the upper chord, and
- a second web wall section extending from another of the angular support walls on the lower chord, the fastening devices connecting the first and second web wall sections with the main web wall.
- 20. A building beam structure of claim 18 wherein the web walls further comprise
- a first pair of web wall sections, each of the first pair of web wall sections extending from one of the angular support walls on the upper chord,
- a second pair of web wall sections each of the second pair of web wall sections extending from one of the angular support walls on the lower chord.

21. A building joist structure comprising:

first and second sheet metal chords, each of the chords having

a flat end wall with opposed longitudinal lateral edges, two generally parallel side walls, each of the side walls having

- a longitudinal first edge extending from one of the longitudinal lateral edges of the end wall,
- a longitudinal second edge, and
- a flat fastening surface between the first and second longitudinal edges of the side wall to which materials may be connected,

two angular support walls converging inwardly from the side walls, each of the support walls having

- a longitudinal first edge extending from the longitudinal second edge of the side wall, and
- a longitudinal second edge;
- a sheet metal central web section connected between the two chords and including
 - a planar main web wall having
 - a longitudinal first edge extending from the longitudinal second edge of the one of the support walls on the first chord, and
 - a longitudinal second edge extending from the longitudinal second edge of one of the support walls on the second chord, and
 - a first web wall section having a longitudinal first edge extending from the longitudinal second edge of another of the support walls on the first chord, and
 - a second web wall section having a longitudinal first edge extending from the longitudinal second edge of another of the support walls on the second chord, the first and second web wall sections extending adjacent the main web wall; and

fastening devices connecting the first and second web wall sections with the main web wall.

- 22. A building joist structure comprising:
- a single sheet metal piece having upper and lower opposed chords connected by a generally vertical web section;

each of the chords having five walls including

a generally horizontal flat end wall,

two generally vertical side walls connected along upper longitudinal edges to the end wall, the side walls having respective flat fastening surfaces to which materials may be connected, and

two angular support walls connected along upper longitudinal edges to lower longitudinal edges of the vertical side walls, the angular support walls converging inward from the vertical side walls; and

the web section including

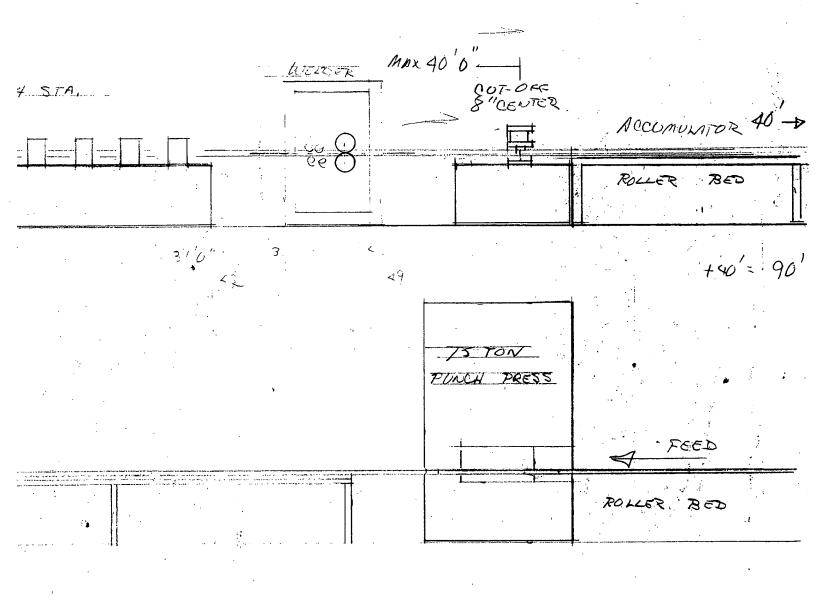
- a first planar web wall connected to first angular support walls on each of the top and bottom chords,
- a second web wall connected to a second angular support wall on the upper chord, and
- a third web wall connected to a second angular support wall on the lower chord.
- 23. A building beam structure of claim 22 further comprising fastening devices connecting the second and third web walls with the first web wall.
- 24. A building beam structure of claim 23 further comprising a plurality of holes spaced longitudinally along the 20 central web section and sized to receive apparatus for utilities.
- 25. A building beam structure of claim 23 wherein one of the side walls of one chord is coplanar with one of the side walls of the other chord, and the other of the side walls of the one chord is coplanar with the other of the side walls of the other chord.
 - 26. A building beam structure comprising:
 - two sheet metal chords, each of the chords having a flat end wall.
 - two opposed side walls extending from the end wall and having respective flat fastening surfaces to which materials may be connected, and
 - one angular support wall, the angular support wall extending from one of the side walls, and the angular support wall converging inwardly from the side walls; and

- a sheet metal central web section disposed between the two chords and including
 - a main planar web wall extending straight between another of the side walls on each of the chords,
- a first web wall section extending from one of the angular support walls on one of the chords, and
- a second web wall section extending from one of the angular support walls on another of the chords.
- 27. A building beam structure of claim 26 further comprising fastening devices connecting the first and second weh wall sections with the main web wall.
 - 28. A building beam structure comprising:
- two sheet metal beam components, each of the beam components having
 - a flat end wall,
 - two opposed side walls extending from the end wall and having respective flat fastening surfaces to which materials may be connected,
 - two angular support walls, each of the angular support walls extending from one of the side walls, and the angular support walls converging inwardly from the side walls, and
 - two sheet metal web walls, each of the web walls extending from one of the angular support walls,
- the two beam components being disposed with respect to each other such that the web walls of one of the beam components overlap the web walls of the other of the beam components; and
- fastening devices connecting the web walls, thereby providing a beam structure having opposed end walls with intermediate and interconnected web walls.

* * * * *



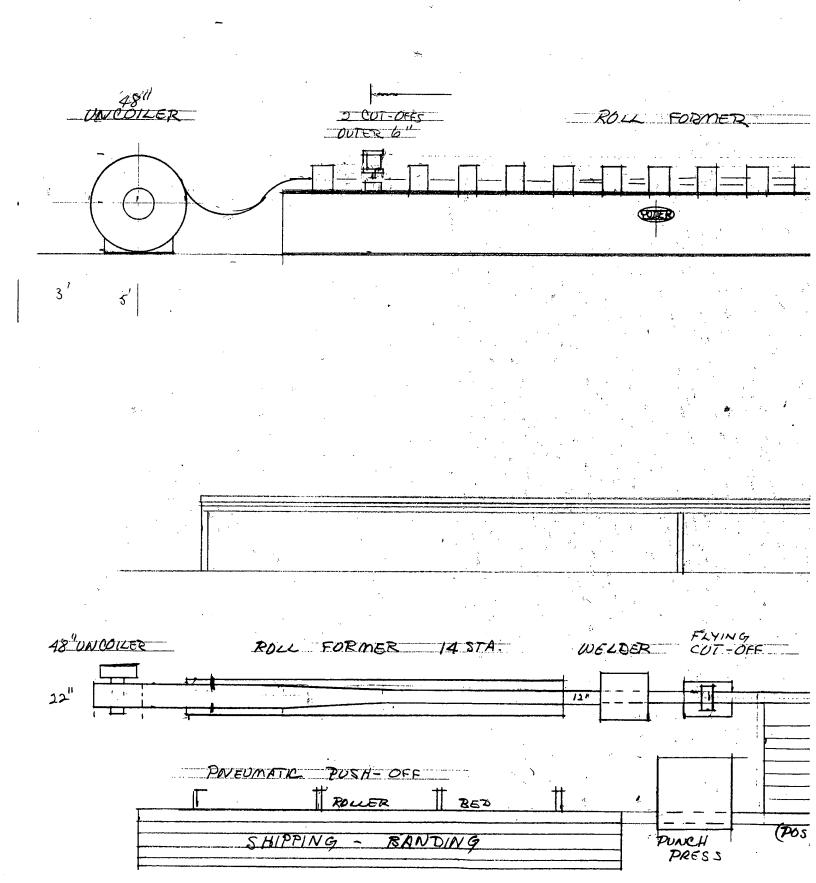
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DAPRELL G MEYER 3-25-95



Oxhibat

AGREEMENT

TRUSSTEEL, Darrell G. Meyer 13269 Soft Cloud Way Victorville, CA 92392

RE: TRUSSTEEL Open Web Steel Floor Truss

The Undersigned hereby acknowledge the proprietary design rights of Darrell G. Meyer, Inventor, of a certain floor truss assembly incorporating resistance electric welding of "U Channnel" vertical and diagonal webs and rectangular tube members. A prototype of which was tested approximately September 20, 1995.

We will not offer for sale, license or manufacture this product or a like type product without the consent and approval of Darrell G. Meyer.

Sincerely,

ANGELES METAL SYSTEMS 4817 E. Sheila Street Los Angeles, CA 90040

TRUSSTEEL

Allan MacQuoid, C.E.O.

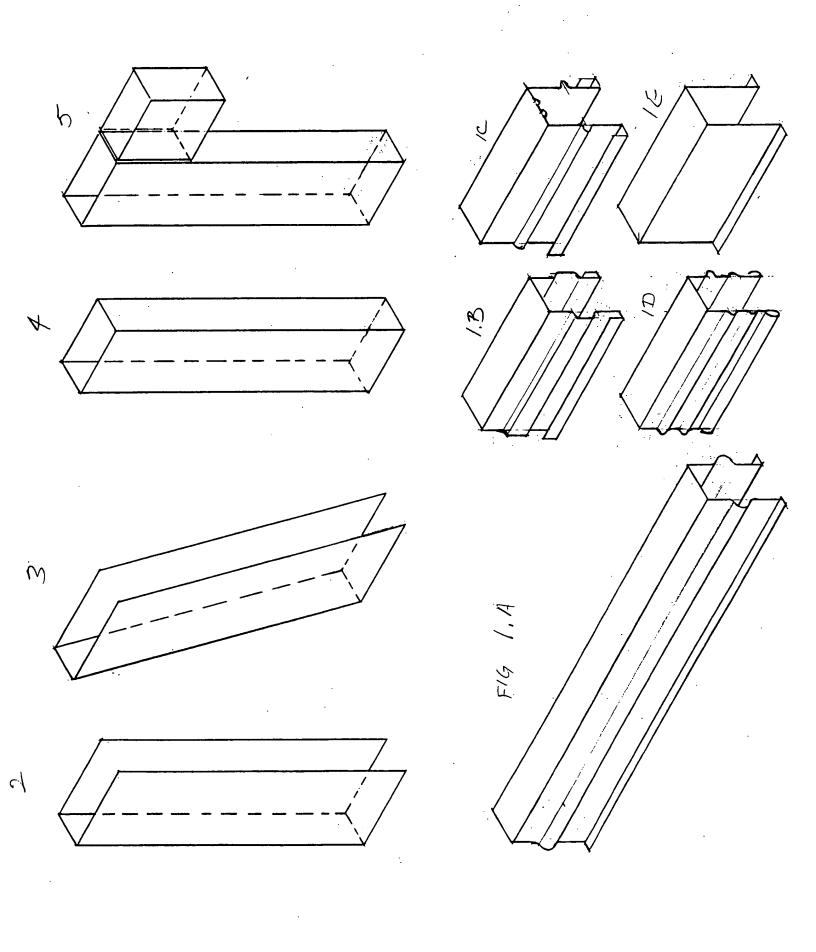
Darrell G. Meyer

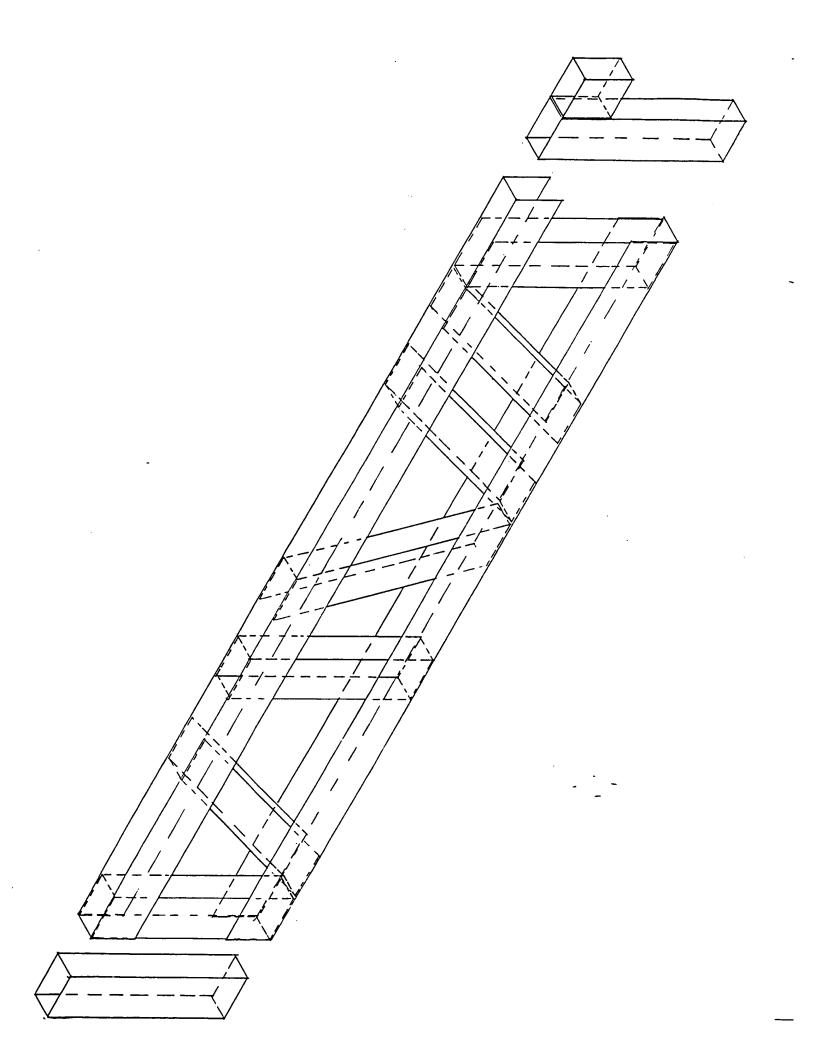
D. Kingston Cable, Chairman

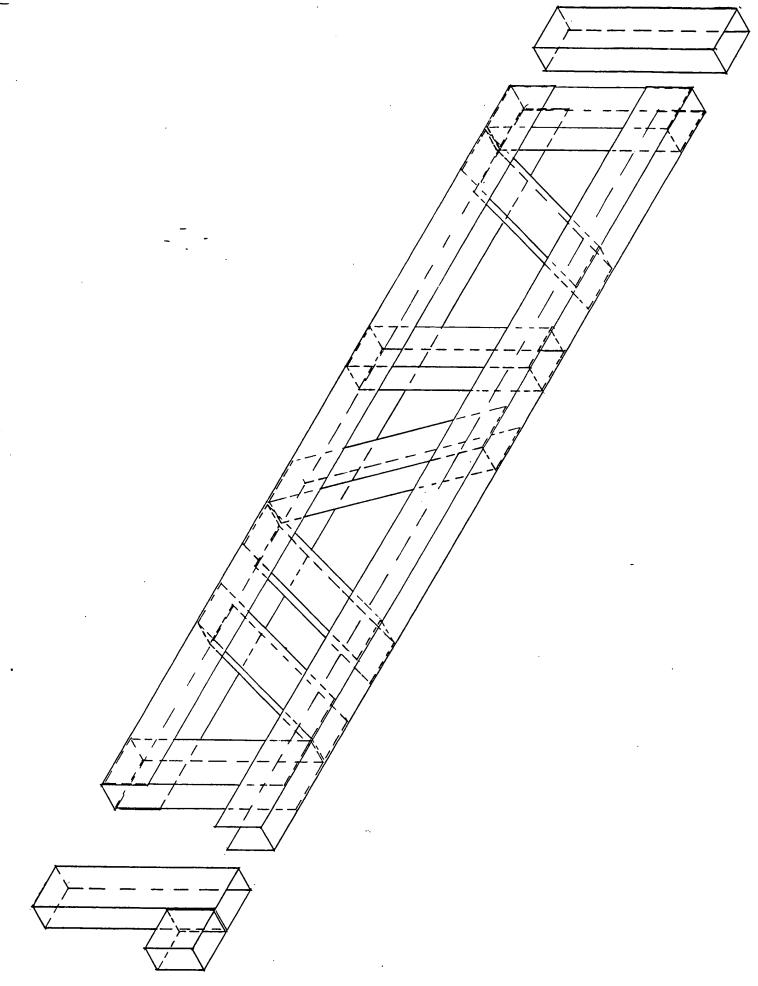
exhibit 3

TO D. KINGSTON CABLE PROTOTYPE & TESTING/60 DAY NOV 6 D.G. MEYER DUG JAN TOTAL DEC 13000 -DARRELL G. MEYER 5000 - 4000 4000 - 4000 3 RETAINER -GOOD FAITH SALARY - DRAW 5 METALURGY-LOELD CONSULT. 500 -500 -11. WEDER-CONTROLLER 12500 -10 BID 11,800 + TAX 6000 -6500 BRIDGE -GANTRY - FESTOONING 3000 -BLD \$ 2800 +T 1500-1500 15 4000 TRUSS ASSY FIXTURE 3000 VERBAL - ANAHEM WELT 16 3000 18 2000-10 ROLLERS - STANDS 19 HYTROL - QUOTE 20 CHAIN SOUM. O DOLLIES 4000 - 20 21 22 2000 23 INSTALL - LABOR, BLECT, AID 3000-24 25 26 44000 -27 TOTAL 26000-28 18000 29 DEC 30 31 SEG 3 MONTH STADT-UP FOR ADDITIONAL EXPENSES 34 35 38

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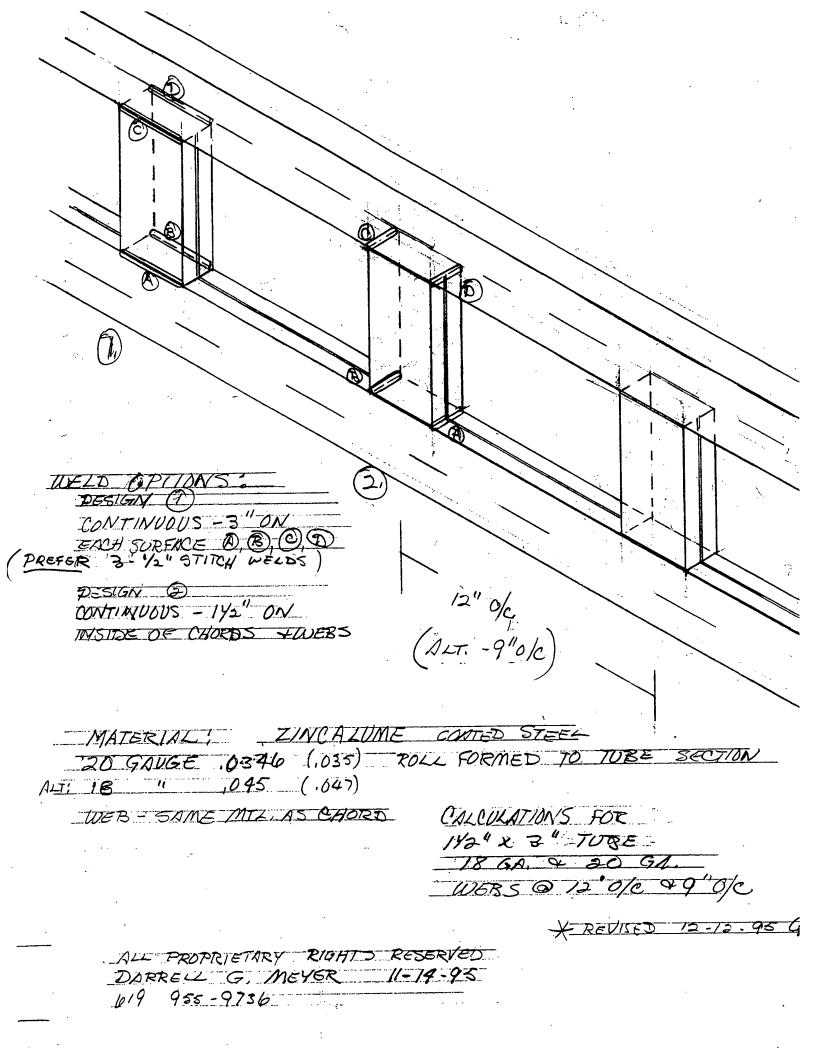






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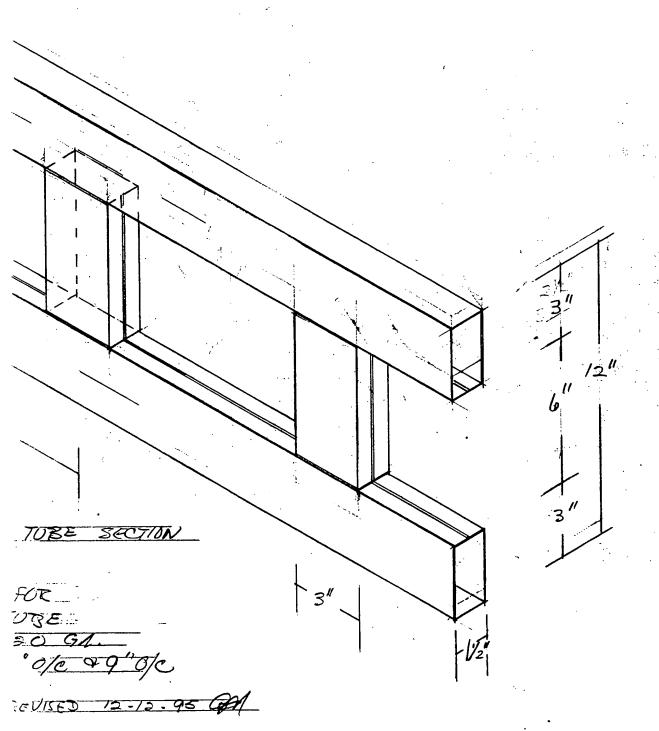
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Cahibil 5

FAX 714 752-5321 12-13-95

TO! SAEED AND WEI



Oshrbat 6

AGREEMENT FOR PROFESSIONAL SERVICES

THIS AGREEMENT IS ENTERED INTO THIS ______ DAY OF DEVISE 1995 BY AND BETWEEN DARREL G. MEYER, (AN INDIVIDUAL), HERINAFTER REFERRED TO AS "DGM", AND GOUVIS ENGINEERING (A CALIFORNIA CORPORATION), HERINAFTER REFERRED AS "GE".

WHEREAS DGM HAS INVENTED A LIGHT GAUGE STEEL SECTIONED FLOOR TRUSS SYSTEM HERINAFTER REFERRED TO AS "THE SYSTEM", AND WHEREAS DGM DESIRE TO RETAIN GE FOR THE NECESSARY STRUCTURAL ENGINEERING DESIGN RELATED TO THE INVENTION, AND WHEREAS GE WHICH HAS THE PROFESSIONAL CAPABILITY TO RENDER SAID REQUIRED ENGINEERING DESIGN SERVICES, DGM AND GE HEREBY AGREE TO THE FOLLOWING TERMS AND CONDITIONS FOR SAID PROFESSIONAL SERVICES.

RECITALS

DGM WILL RETAIN ALL PROPRIETARY DESIGN AND PATENT RIGHTS TO THE SYSTEM, AND WILL ASSUME ANY AND ALL LIABILITIES FOR ANY PATENT INFRINGEMENTS, OR ANY CLAIMS MADE BY OTHERS WHO MAY SEEK REMEDY FOR OWNERSHIP RIGHTS OF THE SYSTEM OR ANY PART THEREOF, AND WILL HOLD GE, AND ALL EMPLOYEES OF GE HARMLESS IF ANY CLAIMS ARE MADE AGAINST EITHER DGM AND/OR GE AND AND/OR ANY OF GE'S EMPLOYEES INCLUDING BUT NOT LIMITED TO COSTS FOR DEFENSE AS TO LAW SUITS INVOLVING DESIGN AND/OR PATENT RIGHTS OR CLAIMS OF PROPRIETARY OWNERSHIP BROUGHT ABOUT BY OTHERS.

GE WILL MAINTAIN ERRORS AND OMISSIONS INSURANCE COVERAGE FOR ERRORS OR OMISSIONS MADE IN THE DESIGNS BY GE BY EITHER SELF INSURING OR BY MAINTAINING A POLICY OF INSURANCE WITH A COMPANY THAT NORMALLY SELLS COVERAGE FOR SAID DESIGN ERRORS OR OMISSIONS. SAID COVERAGE WILL IN NO CASE BE LESS THAN \$250,000.00 AS AN AGGREGATE AMOUNT IN ANY ONE YEAR PERIOD.

GE AND A LIMITED NUMBER OF GE EMPLOYEES IN THE PURSUIT OF THIS AGREEMENT, HAVE KNOWLEDGE OF CERTAIN PATENTABLE IDEAS BROUGHT FORTH BY DGM, AND ALL WILL, ON A BEST EFFORTS BASIS PROTECT THIS SECRET INFORMATION FROM ANY UNRELATED ENTITIES FOR THE BENEFIT OF DGM.

DGM AND GE AGREE THAT THE DEVELOPMENT AND THE FUTURE PROMOTION OF THE SYSTEM WILL REQUIRE AN ON GOING RELATIONSHIP BETWEEN THE PARTIES ABOVE

FIRST MENTIONED AND THAT GE WILL BE COMPENSATED FOR THE NECESSARY PROFESSIONAL DESIGN SERVICES IN THE FOLLOWING MANNER.

GE WILL BE COMPENSATED ON A TIME AND MATERIAL BASIS AT A RATE OF TWICE THE NORMAL THREE TIMES CLOCK. (CLOCK IS HEREIN DEFINED AS THE HOURLY RATE PAID TO AN INDIVIDUAL EMPLOYEE OF GE.) SEE ATTACHED EXHIBIT A WHICH IS THE CURRENT GE HOURLY RATE SCHEDULE FOR THE VARIOUS GE EMPLOYEES. (THE RATES NOTED ARE TYPICALLY MODIFIED UPWARD EACH YEAR TO ACCOMMODATE FOR INFLATION, AND TO AGREE TO THIS DGM HAS INITIALED THIS LINE IN THE RIGHT HAND MARGIN)

GE WILL BE PAID HALF OF THE THEN CURRENT STATEMENT WHEN DEVELOPMENT FUNDING BECOMES AVAILABLE, AND THE OTHER HALF WILL BE PAID WHEN THE BUSINESS HAS A CASH FLOW SOURCE FROM SALES OF THE DEVELOPED PRODUCTION TO INDUSTRY. ALSO AT THAT TIME, AND AFTER ALL PRIOR BILLING IS PAID IN FULL, GE WILL COMMENCE CHARGING FOR SERVICES AT THE NORMAL THREE TIMES CLOCK.

GE WILL KEEP ACCURATE RECORDS OF TIME AND OUT OF POCKET REIMBURSABLE CHARGES FOR ALL WORK DONE IN THE PURSUIT OF THIS AGREEMENT AND WILL RENDER MONTHLY STATEMENTS TO DGM, OR TO ENTITIES HE MAY CREATE, OR AFFILIATE WITH, IN PROMOTING, SELLING OUTRIGHT, OR OTHERWISE USE OF GE EFFORTS IN THIS MATTER.

GE WILL ON A BEST EFFORTS BASIS ASSIST IN SALES OF THE FINAL MARKETABLE SYSTEM BY OFFERING IT'S USE TO THE SEVERAL DEVELOPERS AND BUILDERS WHO ARE CURRENTLY USING THE PROFESSIONAL SERVICES OF GE. IT IS HEREBY AGREED THAT GE WILL BE PAID A FINDERS FEE COMMISSION FOR ANY AND ALL SUCCESSFUL SALES GE MAY CREATE. SAID FEE WOULD BE EQUAL TO THE STANDARD AMOUNT AS WILL BE DETERMINED BY DGM WHEN ACTUAL SALES BEGIN.

IT IS THE BELIEF OF BOTH DGM AND GE THAT THE SYSTEM, AND IT'S ULTIMATE MARKETABILITY IN THE BUILDING INDUSTRY WILL REQUIRE THE ON GOING SERVICES OF GE, AND AS AN INDUCEMENT FOR GE TO REMAIN WITH THE PROGRAM, DGM DOES HEREBY GRANT TO GE A FIVE PERCENT OWNERSHIP / PARTICIPATION OF STOCK OR INTEREST IN THE ENTERPRISE AS ORGANIZED BY DGM. THIS INCLUDES BUT IS NOT LIMITED TO A FIVE PERCENT OF THE GROSS INTEREST IN THE SALE OF THE SYSTEM TO ANOTHER BUSINESS ENTITY.

DGM WILL PROVIDE INFORMATION TO GE FROM TIME TO TIME WHICH WILL REQUIRE THE PROFESSIONAL DESIGN SERVICES BY GE, AND GE WILL PROVIDE SAID SERVICES IN A TIMELY FASHION AS REQUIRED.

TERMINATION

EITHER PARTY MAY TERMINATE THIS AGREEMENT WITHOUT CAUSE UPON WRITTEN NOTIFICATION THIRTY DAYS PRIOR TO THE DATE OF TERMINATION. ALL WORK PRODUCT BY GE WILL IMMEDIATELY CEASE AND ALL BILLING WILL BECOME DUE AND PAYABLE TO GE WITHIN THIRTY DAYS OF SAID TERMINATION. UPON TERMINATION GE WILL WAIVE THE FIVE PERCENT INTEREST IN THE DGM ENTERPRISE IF TERMINATION OCCURS PRIOR TO THE FINAL DEVELOPMENT OF THE SYSTEM AS DETERMINED BY GE.

ARBITRATION

THE STANDARD ARBITRATION RULE WILL PREVAIL IF THERE IS A DISAGREEMENT BETWEEN THE PARTIES WHO HAVE AFFIXED THEIR SIGNATURES BELOW.

ASSIGNMENT

TERMS OF THIS AGREEMENT WILL PREVAIL UPON ALL HEIRS, ASSIGNEES, OR USERS OF ANY NATURE OF THE SYSTEM.

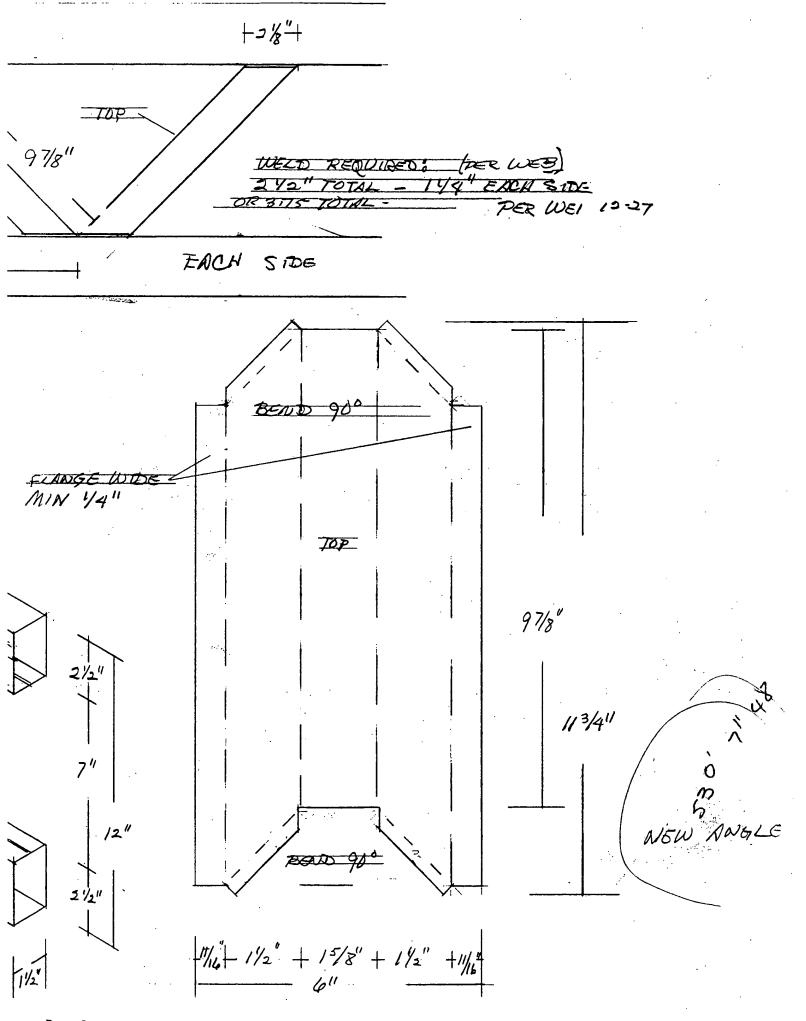
AGREED THIS _ 20 TH DAY OF DECEMBER , 1995

GOUVIS ENGINEERING

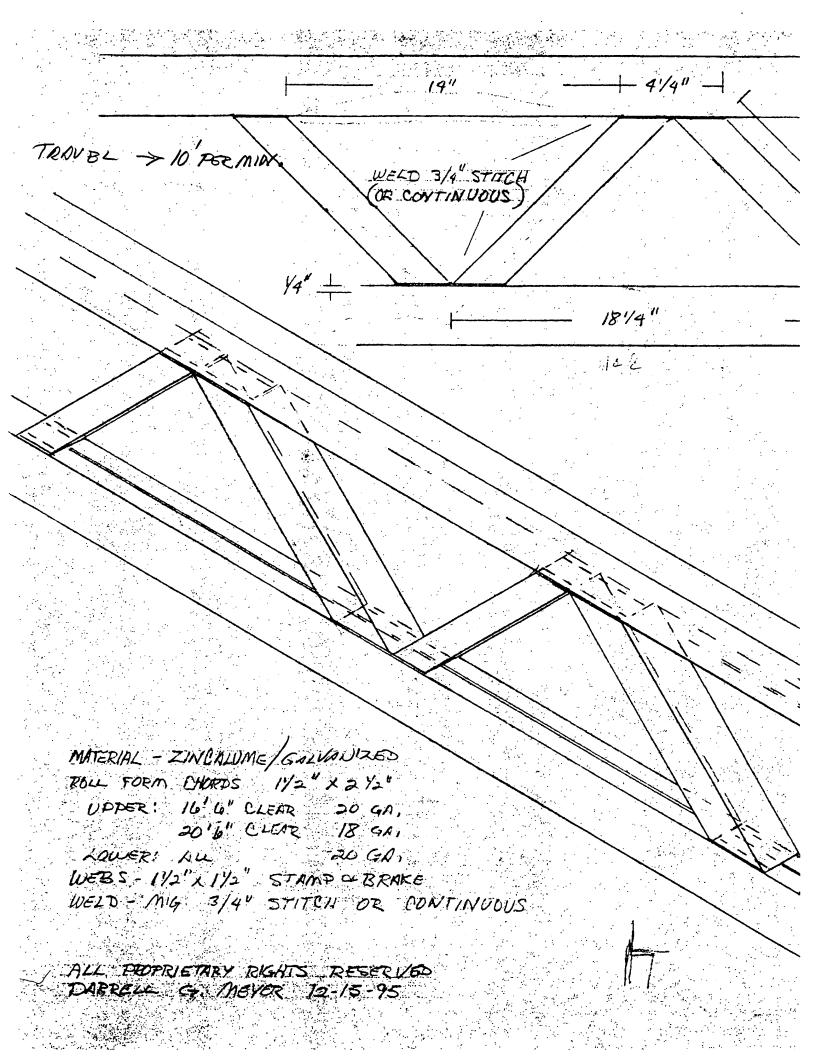
SAEED BEKAM, PRESIDENT

DARRELL G. MEYER 13269 SOFT CLOUD WAY VICTORVILLE, CA. 92392 (619) 955-9736

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Story C. S. DATAGE G MEYER 1-10-96 -20"-HENDER 10157 TRACK (SEG DEWN) MSSZEET 20,0" 20"x2'0" 18GA, SHEET, ROTH SIDES SOREW +,0,1+,9,1Calubat 7

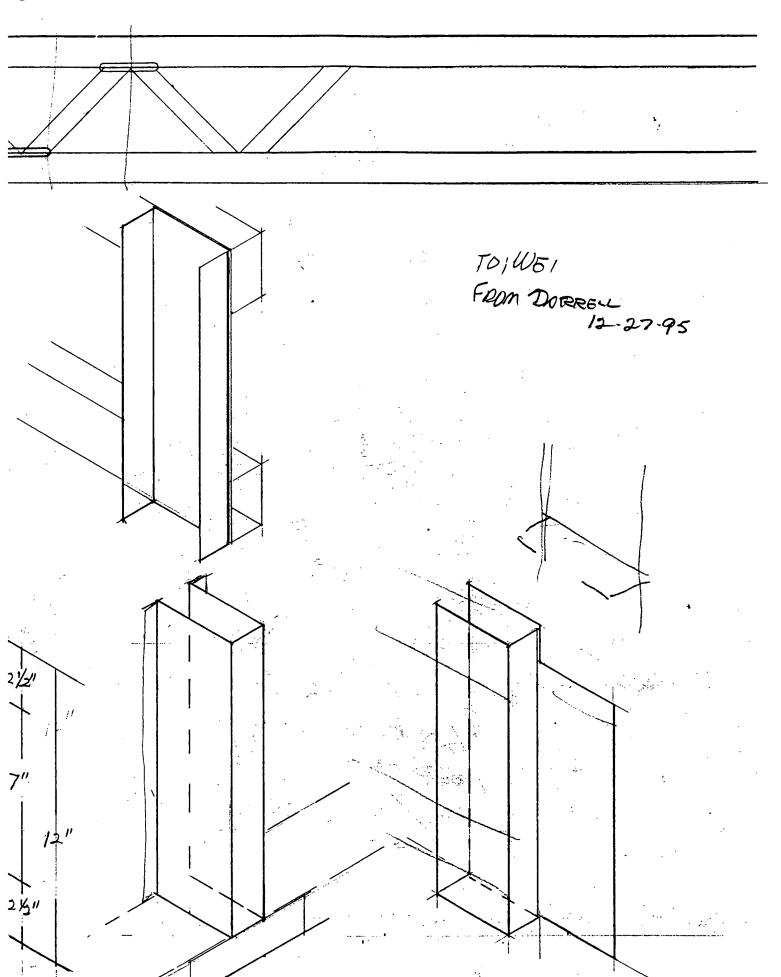


exhibit 8

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WESTERN METAL DRIVE

800 365-5284

UNCOLLETS - BOUBLE USED	15,000
PUNCA PRISS 75 TON USED	3000
TOOLING - DUAL A	25, 900
RULL ChemER 15 574. 3"	40,000
FORTER - SONTROL - PUNCH	17300
TODLING - POLL FORMER	30 000
DAVE MOTOR CONTROL	10 000
FLYING FLANGE, FRAME a CONTROL	25000
TOOLING - FLANGE	30,000
STACKING & CONVEYER EYSTIM	10,000
CLT COT SHIKE - CHUP SIN	10,000
	\$243,000

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Calubrat Lo



February 16, 1996

Mr. Darrell G. Meyer TRUSSTEEL 13269 Soft Cloud Way Victorville, CA 92392

Re: Steel Floor Truss

Dear Darrell:

It was a pleasure meeting you earlier this week and we appreciate the opportunity to consider your steel floor truss idea.

We have run some very preliminary numbers and at this early stage they look encouraging. Some of the things that would help us refine the numbers are the following:

- Load Tables for the Trusses with 20 gage, 18 gage, and a combination of 20 gage and 18 gage chord members.
- Market Prices of competing products (open web only)
- The current size of the open web floor joist market.
- The anticipated roll forming and assembly rate (feet per minute)
- Some details on end treatments (where the web spacing does not work out exactly).

We'll also try to research some of the above, but anything you can come up with would probably accelerate the process. In addition, you should be thinking of how you might want to structure the potential royalty and license agreements. I have some ideas which we can discuss when appropriate, but if your desires are significantly different I would need to consider them in assessing the overall product feasibility.

I'll call you sometime during the week of the 26th to arrange our next meeting.

Very truly yours

Denald R. Moody, President/CEO Oxhibet 11

THU 2.22

ALPINE TRUSS ALFING/UNITHIST 800 755-6005

MAY

3/4"X 3""

NO INTEREST IN FLOOR TRUSS

ESCONDIDO TRUSS

14

CINDY

11 16' 11 38' - 14" 130 16' \$50

16" 15 RISER

\$16511

GUS TRUSS - WESTERN METAL 800 365-528/ COST 3.00 RID 3.80
ROW TUBE

MITEK - DIETRICK MUSE PELLACK

800 - 325 - 8075

ALPINE / UNIMAST \$

800 755-6005

TRI-CHORD

619 588-2591

RETUR \$2.25 (250-265)

NTEGRA

RAY GRAGE - ENGINEER 800 350 RALPOAD ANYOU SOITE A AMAT

BLOG, COMPONENTS TOMEN

989 428-1600

TRUSWALL, ABLINGTON TX 80e 521-9790 PERAS CA4F TRUSS 909 657-7491 POMONA WO MERYPHATEIER 623-2448 TUSTIN BLOREPPANING 714 573-4449

TRUSTOIST MACMILLAN TIL CORORA 800 969-6772 MAR DAVIS 714 937-5055 14"MIN, OPEN WEB, COSTON WED PRICE # 3, 70 3. LOAD 40/10 \$0/00

771, 35 DF 117/8 DOTTH Pas 16"0/2 50 17'7"

20'9" 35 16"0/e 1,50 14/91 24 oc 18'2" 1,50 QUOTELUBER

Pa 24 0/2 2 mins 157 ") 3 3/8"WEB WEIGH 2,2 LBS/FT,

25/16x1/2" > D.F.

THU 2-22

DON METER

TRI-CHORD EL TATION 69 588-2591 CURT KINNEY GAIL VAN AKEN, 2V 702 642 7598 IN L.V.

24" DEPTH 90 18. 28'6" FOR CORD

PRESS JOINT

12" DEPTH

\$1.65 PER FT.

24" O.C. 35' 18' 6" 19.2. 36' 30'

BOT CHOED BEARING

TAMES TRUSS CRAIG ROAD OF IS

12"12'STAN I GIRDER 51,60 LIN. FT.

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ALTINE / UNIMIST 800 755-6005

GRAND PRINCE, TEXAS

JACK DAVID WILLIS 4160

MOTHING IN FLOOR TRUSS

MON 2-27 DAVID WILLS

POOF TROSS JOAN CAPPENTER

22, 20, 18

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MITEK - DETRUK

800 325-8075

TOM

DOES N'T FEEL CONTETETIVE WITH WOOD

DOES MIKE POSITION (WOOD WER)

GANDHE MATTER &

776 . 5944

MARKET POTENTIAL

Wood Truss Council 608/274-4849 5937 Meadowood Dr., #14 Madison, WI 53711

Kirk Grundahl, Exec. Director (Suzy Sandy)

580 members

(3-19-96)

1992 Production:

I Joists - 223 million feet

Parallel Chord (open) - both wood and steel - 221 million feet

Projection year 2000 joint study with NAHB, George Carter *

I Joists - 530 million feet

Parallel Chord - both wood and steel - 290 million feet

May change name to reflect wood and steel

Mitek - both

Open to steel engineered membership.

^{*}Expect increase primarily due to lower lumber quality.

Oshbil 12



GOUVIS ENGINEERING NEWPORT BEACH . SAN DIEGO . PALM SPRINGS

GOUVIS ENGINEERING

FAX TRANSMITTAL

DATE: 2/29/96
TO: DAMMELL METER
FAX NUMBER: 619-955-9736
ATTENTION:
FROM: WE
PROJECT NAME:
GE JOB NUMBER: 12250
NUMBER OF PAGES: 2 (INCLUDING THIS TRANSMITTAL)
REMARKS: I SQUIZED OUT A LITTLE DIT
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THIS TO FIPISH THE TABLE. 2 HOPE
THIS HALF CAN HELP YOU. LET
ME KHOW WHEH YOUR MEETING 15,
IF YOU HAVE ANY QUESTIONS, OR IF YOU DID NOT RECEIVE ALL PAGES, OR PORTIONS OF THIS TRANSMITTAL ARE ILLEGIBLE, PLEASE DO NOT HESITATE TO CALL THIS OFFICE.

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CALIF, TRUSS - DON

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FLOOR JOIST PRODUCT COMPARISON

MAX. SPAN / SPACING / COST DANLYSIS

COMPARISON

	:	00-1	1	,	SPAU	NG		
JOIST DEPTH	JOIST	LIN. FT.	12"	0,0.	16"	O.C.	24	OC.
91/4"	JOIST SERIES 2x10 D/F	, 97	5PAN 17'5'"	COST S.F.	13'11"	COST S. F.	SPAN 12'3"	60ST S.F 48
11 1/4"	2 ×12 0/6	1.24	20'2"	1,24	16'7"	,93	14'3"	,62

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20'			•		·

1/65

TOUSWAL Y€s TJL YE5

1 /360

#21	TOIST JOIST DEPTH SERIES	13"0.0 16" 0.0. COST S.F.	29'00. COS
600 /M	91/4" '2XID SOLIDWD,		
#1+ 620	11/4" 2×12 50+10 WO.	15/3"	12'9"
1,33 UN.	1178 T JI 25 PRO	18'1"	14'9"
1.56 UN	1178" TII/25 DF	21'4"	18'9"
2.88 LW	1178" TII/ 55 DF	29/9"	22'10"
and L		· · · · · · · · · · · · · · · · · · ·	

JOIST JOIST DEPTH SERIES 12" TRUSS WALL (STILLER) 14" TRUSSWALL (STLWEB) 16" 24" WEB (WD) 16" BERRING 800 367-8787 2xx w 2x4 14"

MILGOED TEMECULA 909 676-2688

SALES

7 3/4

FRI- 3=7-96

GANG NAIL FONTANA

16

20

TOE 14" \$ 2070 \$ 280

UP TO 22 UP 8 40 0/A

COSTOM MADE

JOIST JOIST DEPTH SERIES

14" TIL

LIN.

1,38

12/8 LP126

1.98

1178 LP136 31/4 COM

1.56

117/8 LP132

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/	2" 1200 ET 2" 14GA		26'2"		22'10"	

EI 2"
Dep

Den 1100/ 18-7.96 2-3%

TOIST JOIST COST JOST COST SPAN SF SPAN S.F. SPAN COST SPAN S.F. SPAN S.F. SPAN S.F. SPAN S.F. DEPTH JN FT SPAN SF SPAN S.F. SPAN S.F. DEPTH DE #2+ 9/9" \$.97

2×10

2×10

DE #2+ 11/4" \$ 1,24

DE #2 + 11/4" \$ 1,24

TRUSWAL SA. WEB

11,25 \$ 2.70

TRUS WAL 4X2 STL WEB

14.25 \$2.80

DOUG FIR 2x10 #2+

STEEL C

10"

1200 GI

12"

SOURCE D GANAHL LUMBER

000

Calubat 14



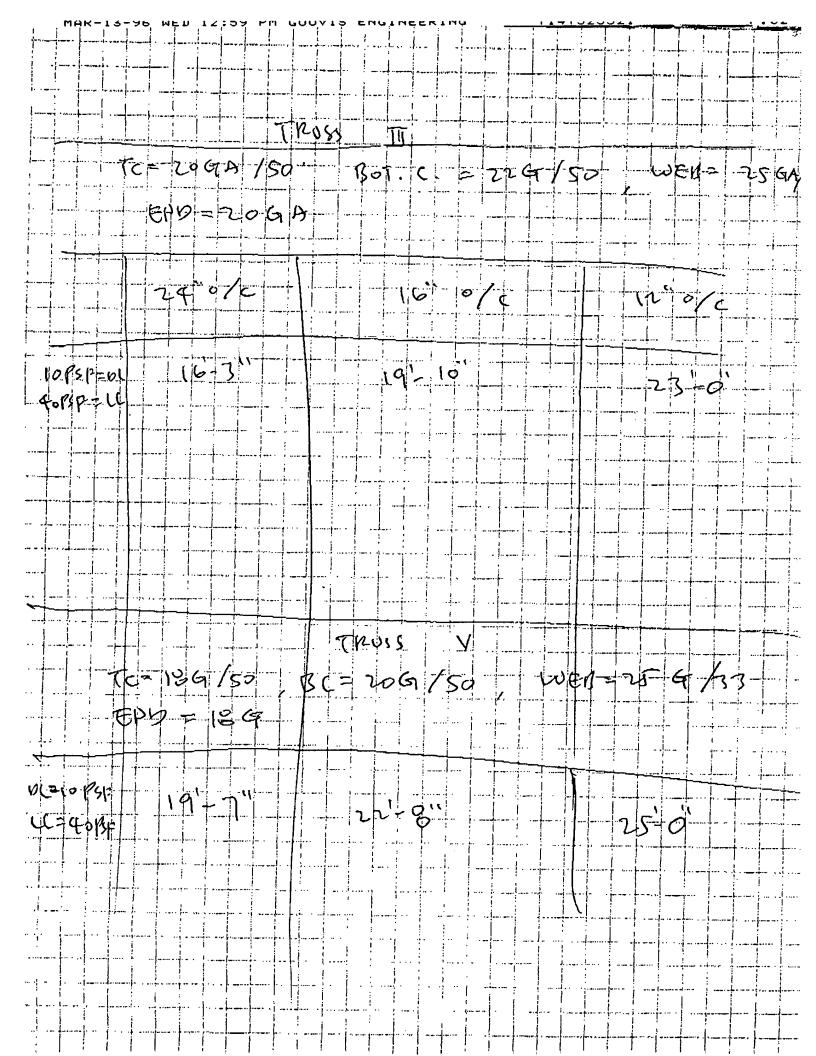
GOUVIS ENGINEERING NEWPORT BEACH . BAN DIEGO . PALM SPRINGS

GOUVIS ENGINEERING

FAX TRANSMITTAL

DATE: 3/13/96
TO: DAMPEL METER
FAX NUMBER: 285-1369
ATTENTION: NAME (
FROM: WE
PROJECT NAME:
GE JOB NUMBER: 12250
NUMBER OF PAGES:(INCLUDING THIS TRANSMITTAL)
REMARKS: FUNTHELL TIPE-TUPIHED
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IF YOU HAVE ANY QUESTIONS, OR IF YOU DID NOT RECEIVE ALL PAGES, OR PORTIONS OF THIS TRANSMITTAL ARE ILLEGIBLE, PLEASE DO NOT HESITATE TO CALL THIS OFFICE.



Oxhibit 15.

TRUSSTEEL JOIST COMPETITIVE PRODUCT COMPARISON Maximum Span / Spacing / Cost

				12"	12" O/C		16"	16" O/C		24.	24" O/C	4.					
Joist	Joist	J			ပ	Cost		ြ	Cost		٥	Cost	Std	ă		Order	Cstm
Туре	Depth Per lin. ft.	Per	lin. ft.	Span	Per	Per sq. ft.	Span	Per	Per sq. ft.	Span	Per	Per sq. ft.	Lgth.	Stk	CTS	Lgth.	Mfg.
1000 EJ 18ga.	10"	⇔	0.88		↔	0.88		↔	99.0		69	0.44	50,			yes	
. 1000 EJ 16ga.	10	€	1.13	23.0"	4	1.13	20'11"	↔	0.84	18'3"	↔	0.57	20,			yes	
1000 EJ 14ga.	10	€>	1.41	24'10"	69	1.41	22'6"	↔	1.06	19'8"	↔	0.71	20,			yes	
.1200 EJ 16ga.	12"	49	1.28	26'9'	€	1.28	24'4"	49	96.0	20'8"	49	0.74	20,			yes	
1200 EJ 14ga.	12"	↔	1.59	28'10"	69	1.59	26'2"	↔	1.19	22'10"	↔	0.80	20,			yes	
TRI-CHORD	12"	69	2.20		↔	2.20		₩	1.65		↔	1.10					yes
TRI-CHORD	<u>4</u>	↔	2.60		69	2.60		↔	1.95		↔	1.25					yes
Trussteel 20 Mga.	12"	₩		23'4"	ss.	2.20	19.40°	69	1.50	1873	49	1.10		40.	yes	yes	yes
Trussteel 18	12"	₩	5.50	72.8. 28.6.	₩	2.50	73,4 25,6	₩	.88 8	. 20 3 10.8"	₩	1.25		.04	yes	yes	yes

BUSINESS FORMATION PLAN AGENDA

- Form new stock corporation (Corp)
 Issue stock 50% Angeles Metal Systems (AMS)
 Issue stock 50% Darrell G. Meyer (DGM)
- Elect officers & board
- Determine legal & accounting firm/method
- AMS Loan (capitalize) Corp. commitment \$100,000
- Purchase order & check procedure
- Inventor (DGM) proceed with patent application (use patent)
- DGM assign patent rights to Corp, same distribution license fees

BUDGET (DETAIL SHEET 1) MACHINES, TOOLS & FIXTURES

1.	Automatic Resistance W See Janda Propo		·	\$45,000
2.	Truss Assembly Jig Anaheim Welding	g - verbal		\$6,000
3.	Rollers, Stands Hytrol - verbal	Rollers Stands Tax, freight	\$1,254 472 <u>240</u> \$1,966	\$2,000
4.	Chain Transfer, Accumu 3 - 12' chain asse electric drive, pn custom - Bid - A	mblies, frames eumatic lift	g	\$4,000
5.	Miller Spot Welder & O Air \$2,000, elect			\$3,000
6.	Racks, Dollies, Chord H	andling Lifts		\$5,000
7.	Banding, Shipping			\$2,000

SCHEDULE TO 3 MONTH START-UP

Engineering

\$5,000

Provide load / span tables, start ICBO

Advertising & marketing

Draft copy and layout to start campaign with engineers, place ads in trade magazines, Metal Home Digest, Automated Builder

Salaries

Darrel G. Meyer to supervise all custom manufacturing, purchase equipment, layout plant, participate in marketing and sales. Joe Mackewich in strong sales program, brochures, ads, personal calls

Rent

Locate approx. 12,000 s.f. within Angeles facility. Rent @ 20 cents per s.f. - \$2,400

Utilities

TRUSSTEEL JOIST PRODUCT COMPARISON WOOD FLOOR JOISTS MAXIMUM SPAN-SPACING-COST

L/360 Live Load Deflection--40#LL+10#DL

Joist Lin FL Span Sq. FL Ingth. Stock CTS Ingth. Stock CTS Ingth. Stock Stock <th< th=""><th></th><th></th><th></th><th></th><th>12"</th><th>12" O/C</th><th>16" O/C</th><th>ر کرد</th><th>24" O/C</th><th>O/C</th><th></th><th></th><th></th><th></th></th<>					12"	12" O/C	16" O/C	ر کرد	24" O/C	O/C				
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	4,00	16		2.80		\$2.80		\$2.10		\$1.40				yes

Source:
GANAHL
ESCONDIDO TRUSS
CALIFORNIA TRUSS
TJI McMILLAN
GANGNAIL

WOOD FLOOR JOISTS MAXIMUM SPAN-SPACING-COST TRUSSTEEL JOIST PRODUCT COMPARISON

L/360 Live Load Deflection--40#LL+10#DL

			CHLTAUSS	8	GAN	(H) ~	שרוש ביין
٠.			w.d.	3.42	3.04	1.04	UPDATE 7-10
GangNail 4x2 4x2 GangNail 4x2 4x2	Louisiana Pacific: LPI 26 LPI 36 2 1/4" LPI 32	TrustJoist TJL 4x2 TrustJoist TJL Lam	Truswal 4x2 stl wb Truswal 4x2 stl wb	Wood Web 4x2 4x2 Wood Web 4x2 4x2	Trus Joist: TJI 25 Pro 1,6/ TJI 25 DF TJI 55 DF	Doug Fir 2x10#2 Doug Fir 2x12#2	Joist type/series
o 1	11 7/8" 11 7/8" 11 7/8"	7 7	11 1/4" 14 1/4"	16	11 7/8" 11 7/8" 11 7/8"	9 1/4" 11 1/4"	Joist Depth
\$ 2.70 \$ 2.80	\$ 1.38 \$ 1.94 \$ 1.56	\$ 3.40 \$ 4.00	\$ 2.71 \$ 2.97	\$ 2.36 \$ 2.50	\$ 1.33 \$ 1.56 \$ 2.88	\$ 0.97 \$ 1.24	Cost Lin Ft.
	22'8" 23'9" 24'6"		23'4" 27'5"		23'4" 28'8"	17'5'' 20'2''	12" Span
\$2.70 \$2.80	\$ 1.38 \$ 1.94 \$ 1.56	\$ 3.40 \$ 4.00	\$2.71 \$2.97	\$ 2.36 \$ 2.50	\$1.33 \$1.56 \$2.88	\$ 0.97 \$ 1.24	Cost Cost Cost Cost Span Sq. Ft. Span
	20'9" 23'0" 22'0"		19'3" 20"7"		18'1" 21'4" 26'1"	13'11" 16"7"	1 =
\$2.02 \$2.10	\$1.04 \$1.49 \$1.17	\$2.55 \$3.00	\$2.03 \$2.22	\$1.77 \$1.88	\$1.00 \$1.17 \$2.16	\$0.72 \$0.93	O/C Cost Sq. Ft.
	17'2" 20'0" 18'10"		12'10" 13'8"		14'9" 18'4" 22'10"	12;3; 14;3;	24" O/C
\$ 1.35 \$ 1.40	\$0.69 \$0.99 \$0.78	\$1.70 \$2.00	\$ 1.36 \$ 1.49	\$1.18 \$1.25	\$0.67 \$0.78 \$1.44	\$ 0.48 \$ 0.62	Cost Sq. Ft.
						20, 20,	Std Lngth.
	4 4 4				4 4 4		Dir. Stck
	yes yes				yes yes		CTS
yes yes		yes yes	yes yes	yes yes	·		Cstm Mfg.

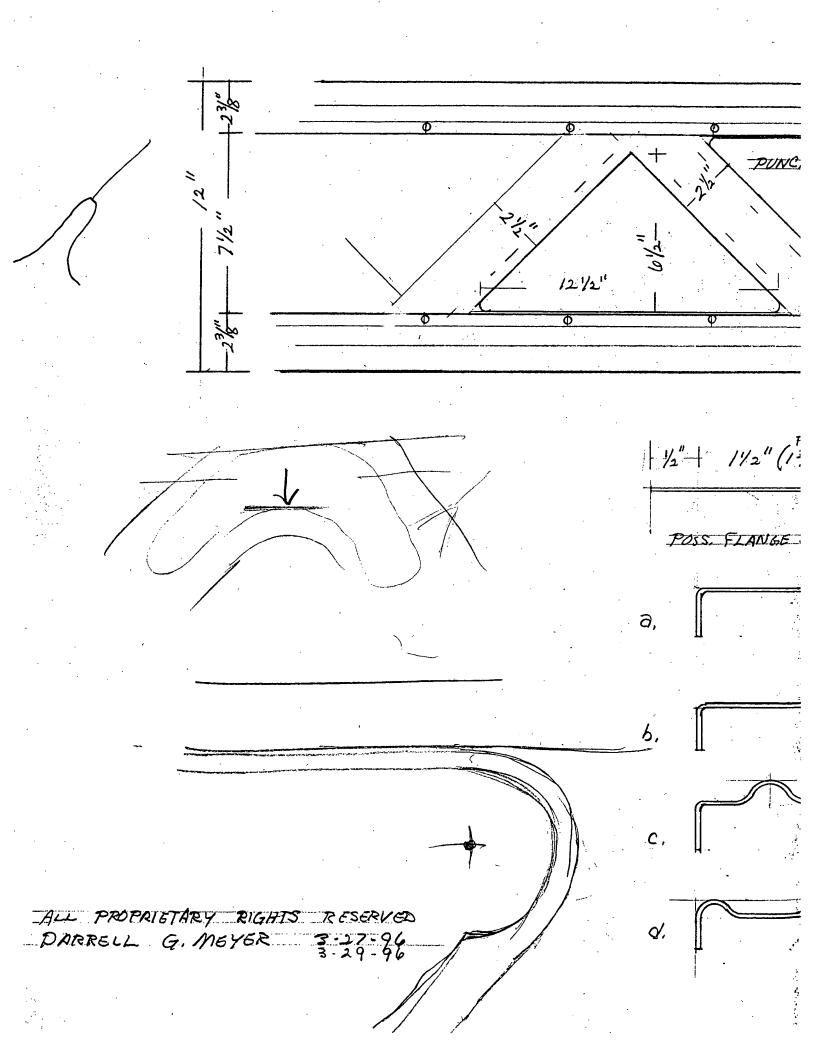
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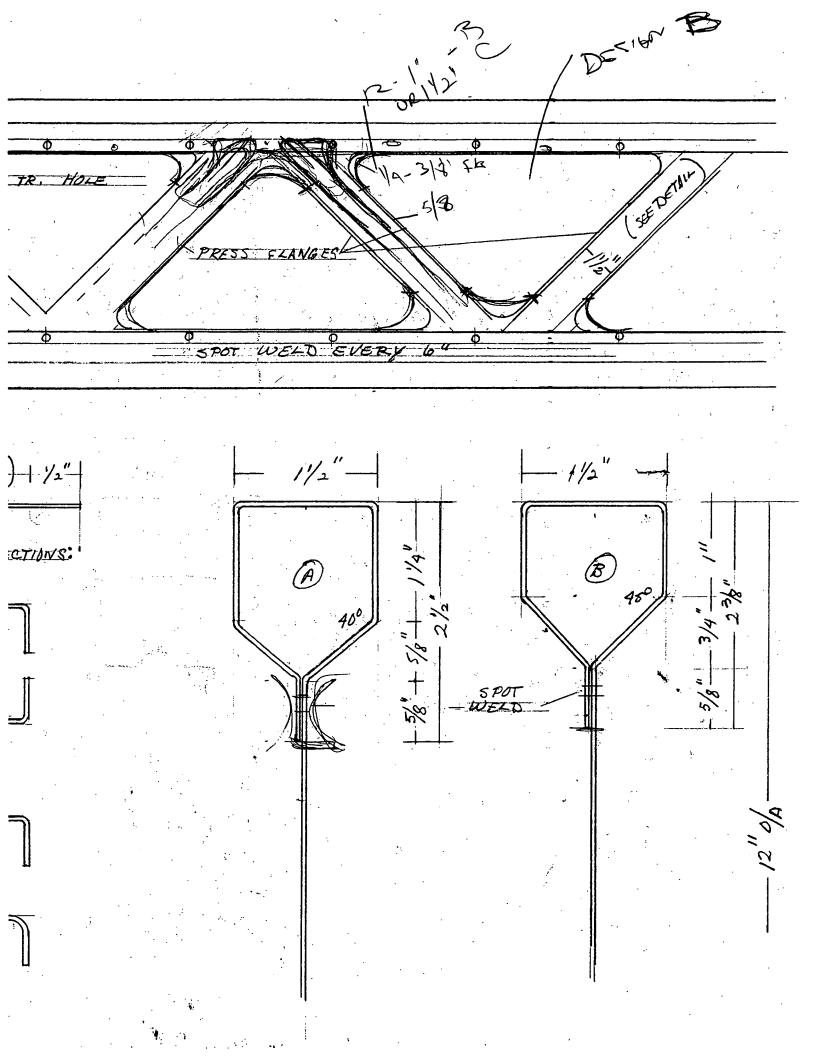
Source: & TYA.
GANAHL & TRUSS
CALIFORNIA TRUSS
TJI McMILLAN
GANGNAIL タイプスと

12 MOS. PRELIMINARY CASH FLOW PROJECTION (INCLUDING 3 MOS. START-UP) POSTIVE <NEGATIVE>

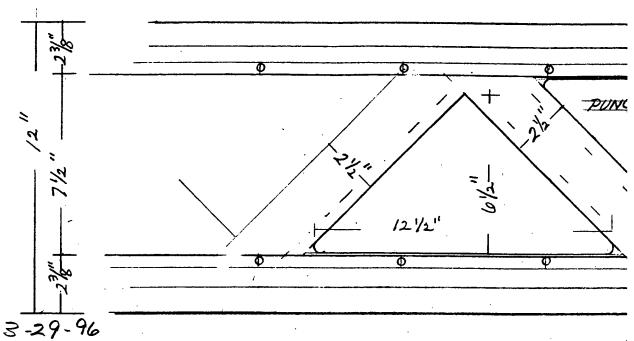
	J0 %	Total										
	Schedule	3 mos.	4	5	9	7	œ	6	10	11	12	Total
Sales Revenue (1)		-0-	(E) 50,000	(E)100,000	(E)100,000	150,000	150,000	150,000	150,000	150,000	150,000	1,125,000
Cost to Produce (2)						86,000						:
Gross Profit / Margin						64,000						
Selling - Commission	(3%)		1,500	3,000	3,000	4,500						
Market - Advertising	(3%)		1,500	3,000	3,000	4,500						
Total Selling Cost			3,000	000'9	000'9	000'6						
Profit Before Expenses, G & A	(36%)		18,000	36,000	36,000	55,000	55,000	55,000	55,000	55,000	55,000	420,000
Expenses												
Engineering - Consultant			1,000	1,000	1,000	1,000						
Salaries - Officers						4,000						
Rent						2,400						-
Utilities						1,500						
Telephone						200						
Vehicle, Travel, Entertainment						800						
Legal & Accounting						1,000						
General Office Expense, postage etc						200						
Insurance - Liability	(2%)					3,000						
Depreciation 120 mo - 60 mo.						2,000						
Total Expenses	(11%)		16,700	16,700	16,700	16,700	16,700	16,700	16,700	16,700	16,700	150,300
Total Startup, Machines, Fixtures, Jigs-3 mo		116,500										
Monthly over <short></short>			1,300	19,300	19,300	38,300	38,300	38,300	38,300	38,300	38,300	269,700
Cash Flow over <short></short>		<116,500>	<115,200>	<006'56>	<0009'9/>	<38,300>	ф	38,300	76,600	114,900	153,200	
Net Cash after 12 mos.											+116,500	
Net Profit										_		269,700

Oschubet 16





Oschubit 17



FR1 3-29-96

DEAR WICK -THIS COMPOSITE DRAWING REFLECTS CHOICE OF TOP/BOTTOM CORD SECTION-ETTHER A OR B-AND POSSIBLE SECTIONS TO BE STAMPED IN WERSO

1/2" /1/2" (1

POSS. FLANGE

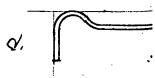
WED INDICATED PROPERTIES SEEM SIMILAR & O.K.

· a,

DON MOODY - WESTERN, SAID HE FERLY LIKED IT! "YOU NOVE & HONE RUN"

NOT PROPETICA

ALL PROPRIETARY RIGHTS RESERVED DARRELL G. MEYER



Oschubat 18

LETTER OF INTENT

This Agreement is entered into this day by and between the following Parties:

Darrell G. Meyer, (Hereinafter referred to as DGM)

Western Metal Lath (Hereinafter referred to as WM).

Recitals:

DGM has invented and is in the process of obtaining a patent (patents) on a fabricated steel "Trussteel Joist" and has developed know-how in connection with said invention.

WM desires to acquire an option to investigate said DGM invention and if favorable to proceed with license to manufacture said "Trussteel Joist", per License Agreement format as mutually agreed.

DGM will grant WM option for \$75,000 payable: \$25,000 upon execution of Option Agreement, \$25,000 when satisfied and enters into License Agreement and \$25,000 upon start-up of production.

DGM will share know-how with WM and coordinate engineering, testing of trusses, design of special machines, fixtures and components for manufacturing and such activities as per WM. DGM will be compensated at the rate of \$5,000 per month, not to exceed 6 months, time of start-up or termination of option.

Outside services required or requested will be submitted to WM for prior approval and payment by WM.

Royalty rate of 4¢ per foot of sales with minimum annual royalty of \$40,000

WM to have exclusive license for 12 western states.

GRAN	TO	R
Darrell	G.	Meyer

GRANTEE
Western Metal Lath

By	By
Darrell G. Meyer	Donald R. Moody, President/C.E.O.
18 Vista Encanta	6510 General Drive
San Clemente, CA 92672	Riverside, CA 92509
(714) 361-9295	(909) 360-3500

Oxhibit 19



April 23, 1996

Mr. Darrell G. Meyer TRUSSTEEL 13269 Soft Cloud Way Victorville, CA 92392

Re: Steel Floor Truss

Dear Darrell:

This is verify that Western Metal Lath is interested in obtaining exclusive manufacturing, marketing, and distribution rights for the western United States for the light gage steel floor truss you are developing. During our discussions we have reached tentative agreement on the following terms and conditions:

- Western's exclusive manufacturing, marketing, and distribution area would include the states of California, Washington, Oregon, Montana, Idaho, Colorado, Utah, Nevada, Arizona, New Mexico, Wyoming, Texas, Alaska, and Hawaii.
- In exchange for the exclusive rights described above, Western would pay you a one time license fee of \$75,000 plus the amount you invest in the development of this product (engineering, testing, documentation, patents, etc.) between now and the time the license agreement is formalized and agreed upon. Any expenditures made by Western toward the development of the product would apply against the final negotiated licensing fee.
- In addition to the license fee, Western would pay you a royalty of \$.04 per lineal foot of truss produced and sold by Western with a guaranteed minimum of \$40,000 per year in toyalties, regardless of sales.

This letter, while expressing our interest and general agreement to the preliminary terms of the anticipated licensing arrangement, is not an agreement of any type between Western Metal Lath and Darrell Meyer. Prior to entering into any agreement beyond mutual cooperation toward the development of the product, the floor truss will have to be fully developed to the extent that a patent has been obtained, certified engineering data substantiated by testing exists, and an IBC-ER approval has been obtained. Additionally, the final agreement will require the approval of Western Metal Lath's Board of Directors.

That being said, we would like to emphasize our belief the floor truss you are developing, based on our preliminary analysis, is a viable product that will be well positioned to participate in the very significant open web floor joist market. We appreciate the opportunity you have presented to us and look forward to a long and mutually beneficial relationship with you.

Very truly yours,

Sonald R. Moody, P.E.

President/CEO

Oxhibit 20

QUOTATION LETTER

No. 02719

LANE AND RODERICK, INC. 12640 Allard Street

Santa Fe Springs, CA 90670 TELEPHONE: 1-310-868-3465 1-310-929-8791

TO:

TRUSSTEEL INC.

13269 SOFT CLOUD WAY VICTOR VILLE, CA 92392

ATTN:

DARRELL MEYER

RFQ.#:

DELIVERY

2 WEEKS

FOB

SANTA FE SPRINGS

SHIP VIA

UNIT PRICE

DATE: 05/14/96

YOUR TRUCK

PHONE: (714) 361-9295

FAX: (714) 285-1369

QUANTITY ITEM# 1

DESCRIPTION QUOTE# 08631

TRUSS 240.00 LONG REV N/C

TRUSS 240.00 LONG

3

384.17

1,152.51

EXTENSION

335.10

1,340.40

ITEM#

OUOTE# 08631

\$1,450.98

SHEAR, LASERCUT FORM AND SPOT WELD

CUSTOMER SUPPLIED 20 GA ZINCALUM PER BP

Quoted By: Warren, Brian C.

UNLESS OTHERWISE STATED HEREIN; PRICES REMAIN IN EFFECT 30 DAYS; PRICES DO NOT INCLUDE LOCAL OR STATE TAXES IF APPLICABLE; TERMS NET 30 DAYS WITH APPROVED CREDIT; FOB FACTORY; UNPAID BALANCES 30 DAYS PAST DUE WILL BE SUBJECT TO AN INTEREST CHARGE OF 1.5% PER MONTH (ANNUAL RATE 18%) FUTURE ORDERS WILL BE AUTOMATICALLY SOLD ON A C.O.D. BASIS

Exhibit 21

Lane & Roderick, Inc.

Metal Fabricators for Industry

PACKING S L I P No. 03516

12640 Allara Street Santa Fe Springs @ 90670-4708 - (310) 868-3465 - Fax (310) 929-8791

Page

SHIP TO:

TRUSSTEEL INC. 13269 SOFT CLOUD WAY VICTOR VILLE, CA 92392

Phone: (714) 361-9295

P.O. No. VERBAL

Ship Via YOUR TRUCK Terms COD

Date Shipped CustID 06/03/96 T1035

Quantity

Description

TRUSS 240.00 LONG TRUSS 240.00 LONG

Rev : N/C

(Our Number 05796)

1 EA. CUSTOMER BLUEPRINT

Date: 6 15 196

UNPAID BALANCES 30 DAYS PAST DUE WILL BE SUBJECT TO AN INTEREST CHARGE OF 1 1/2% PER MONTH (ANNUAL RATE 18%) FUTURE ORDERS WILL AUTOMATICALLY BE SOLD ON COD BASIS

Calubrt 22

WESTERN METAL LATH

6510 GENERAL DRIVE RIVERSIDE, CA 92509 (909) 360-3500

DRAWN ON PNC BANK, OHIO, NATIONAL ASSOCIATION MILFORD, OHIO IN COOPERATION WITH WELLS FARGO BANK, N.A. #4789-608880

86-204/422

Nº 001133

DATE 6/5/96

PAY	ONE	THOUSAND	FOUR	HUNDRED	FIFTY	AND	98/100********	DOLLARS	\$ 1,450.98****

TO THE ORDER OF

LANE AND RODERICK, INC.

MESIENN WEIAL TAIH

#********************************

? 70 9B 25 29 P

DATE	NUMBER	DESCRIPTION	ACCT. NO.	GROSS AMOUNT	DEDUCTIONS	NET AMOUNT
		SEE ATTACHED	41080500	1450.98		1450.9
	1					

Printed on recycled paper to protect the environment.

WESTERN METAL LATH
6510 GENERAL DRIVE, RIVERSIDE, CA 92509
(909) 360-3500

DETACH BEFORE DEPOSITING

GBF 9G-73G

Oxhubit 23



RESOURCES
APPLICATIONS
DESIGNS &
CONTROLS. INC.

June 14, 1996

3220 E. 59TH STREET -LONG BEACH, CA 90805 TELEPHONE: (310) 272-7231 TELECOPIER: (310) 529-7513

Mr. Darrell Meyer Trussteel 18 Vista Encanta San Clemente, CA 92672

Re: RADCO Proposal PR-T6074

Dear Mr. Meyer:

Based on our discussions on June 12, 1996, we will schedule an R&D test of your steel trusses as follows.

- Trussteel will furnish all materials, including trusses, decking, cross bracing and fasteners.
- 2. RADCO will provide the supports for each end of the truss assembly.
- 3. Trussteel will arrange, at Trussteel cost, for the delivery and pickup of lead ingots for use as dead weights.

The test will be performed on only one assembly, consisting of three trusses at 24" oc by approximately 20 feet long. The test procedure will be essentially in accordance with ASTM E 73, Static Load Testing of Truss Assemblies.

The test sequence will be:

- 1. Load the assembly to dead load in two increments. Take deflection measurements.
- 2. Load the live load in four increments, with five minutes between each increment. Take deflection readings after each increment.
- 3. Unload the assembly, allow it to recover, and take deflection readings.
- 4. Reload the dead and live load in four equal increments, and then continue loading until 2 ½ times live load is reached.

The cost for this test is \$1200.00.

Two copies of this letter are enclosed. Please indicate your acceptance of this proposal by signing one copy below and returning it with your check for \$600.00. The balance will be due upon completion of the test.

Sincerely,

RADCO

ACCEPTED: Trussteel

R.F. Tacker, P.E.

⊉resilent

RFT/mdc

Date:

FRONT/PROP/PR-T6074

Oxhibit 24

TRUSSTEEL

June 18, 1996

Mr. Donald R. Moody, P. E., President, C.E.O. Western Metal Lath 6510 General Drive, CA 92509

Re: Trussteel floor joist static load test

Dear Don:

All necessary arrangements have been made for the testing of the 3-20' floor joistsat the facilities of RADCO, Long Beach, CA, per their proposal enclosed.

The budget items are itemized below:

RADCO test	\$1,200
Rental of 12,000 lbs. lead	600
Freight to deliver & pick-up lead	504
Welding of 3 joists (Janda)	195
Labor	150
Plywood & fasteners	140
Hat channel & flat strap	20
Labor to load & unload lead, set up	200
	\$3,059

Per agreement, please remit a check in the amount of \$3,000 to Darrell G. Meyer and I will proceed with the test schedule per your request for the week of June 24,1996.

Ilook forward to our test results and a great future.

Very truly yours

Darrell G. Meyer

DGM: BM

18 VISTA ENCANTA, SAN CLEMENTE, CA 92672

eahbeles

TRUSSTEEL

FUNNI JEG

CLIENT:TRUSSTEEL

PRELIMINARY

STATIC LOAD TESTING OF TRUSS ASSEMBLIES, ASTM E-73-83 (reapproved 1991)

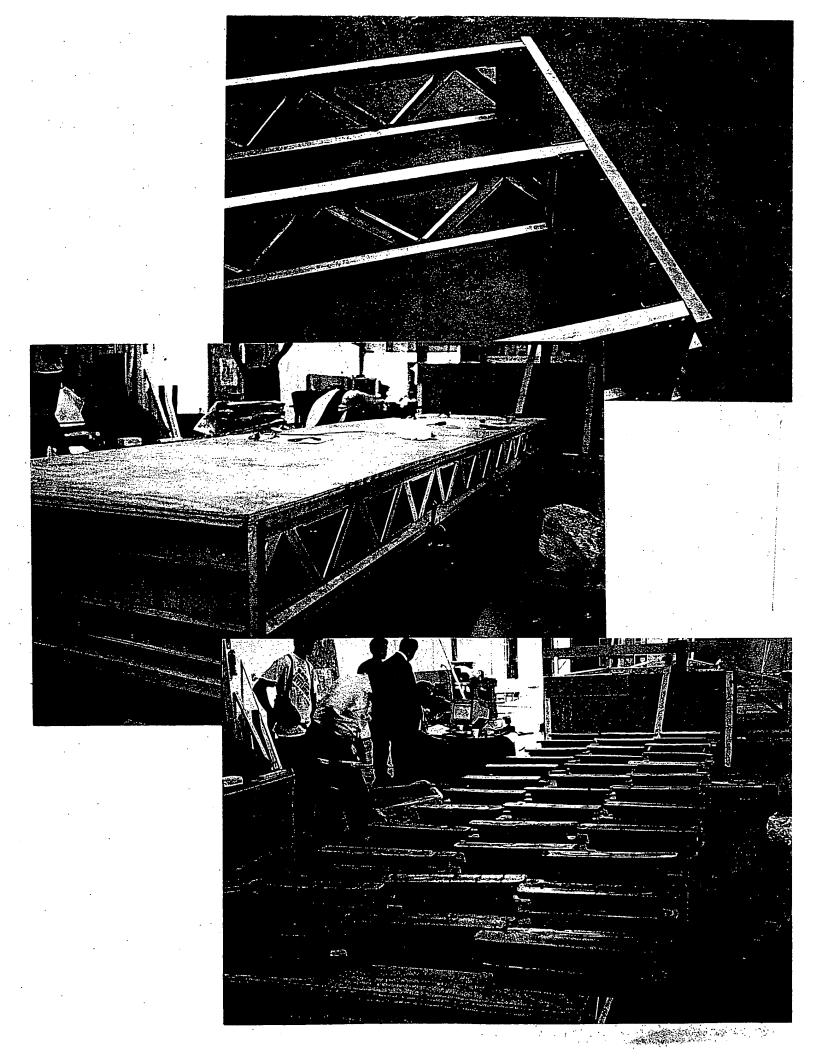
:	STATIC	STATIC LOAD TESTING O	ING OF IN	USS ASSE	F IRUSS ASSEMBLIES, ASIM E-13-65 (reapployed 155	21 m E-/ 3-0	o idappi c	1001				
Date:	Jul 3, 1996	,								[
Time:	1:30 PM			0	P4		0	t <u>. </u>	0	<u>&</u>		
Specimen Size:	4ft.x19ft.8" (236")			,				-				
Wt. of Lead Ingots	70 lbs. each				[(90	_	
Specimen Type:	Steel Truss			0	P4		2	_			<u></u>	
Actual Loading Area:	118 sq. ft.											
				([<u>7</u>		8			&		
Failure Load: (lbs.)	8400			Q								
Failure Load: (psf)	71.186										Actual Load	P60
Applied Load	oad				De	Deflections (In.	ᅵ			1	ייייייייייייייייייייייייייייייייייייייי	
live load increments	l psf (nominal)	P1	P2	P3	P4 .	P5	P6	P7	P8	Pg	DS.	B
Initial (zero load)	0	0.000	0.0000	0.000.0	0.000	0.0000	0.0000	0.000	0.0000	0.0000	0007	40
0.25 live Load	10 psf	0.1179	0.1700	0.1251	0.1245	0.1747	0.1381	0.1340	0.1820	0.1360	1200	2
After 5 min hold		0.1181	0.1700	0.1251	0.1252	0.1747	0.1381	0.1340	0.1820	0.1360		
O 5 Live Load	20 nsf	0.2414	0.3424	0.2514	0.2594	0.3501	0.2727	0.2480	0.3500	0.2630	2520	21.3
After 5 min hold	20 07	0 2442	0.3441	0.2531	0.2619	0.3515	0.2754	0.2450	0.3520	0.2640		
O 75 1 ive 1 ood	30 nef	0.3613	0.5024	0.3694	0.3858	0.5235	0.4061	0.3750	0.5320	0.3970	3780	32.0
O. / 3 LIVE LOGO	2000	0.3648	0.5053	0.3712	0.3878	0.5239	0.4086	0.3770	0.5350	0.3980		
After 5 min. ribid	40 nef	0.0010	0 6762	0.4986	0.5187	0.6987	0.5399	0.4920	0.6950	0.5160	4830	40.9
Ager 6 min hold	200	0.4973	0 6840	0.5047	0.5234	0.7022	0.5448	0.4950	0.6990	0.5170		
Aiter 3 IIIIII. IIOIG	Zero Load	0.0530	0 0490	0.0434	0.0131	0.0341	0.0337	0.0170	0.0290	0.0180	0	
After 5 min hold	- Zelo Logo	0.0342	0.0490	0.0414	0.0123	0.0328	0.0329	0.0150	0.0290	0.0170		
Alter 3 Hills Hold	40 nef	0.5174	0.6761	0.5086	0.5294	0.7138	0.5506	0.5000	0.7170	0.5050	4830	40.9
After 5 min hold		0.5183	0.6770	0.5095	0.5303	0.7149	0.5513	0.5020	0.7200	0.5070		
1 50 Live Load	60 psf	0.7678	0.9551	0.7634	0.7861	1.0518	0.8132	0.7320	1.0340	0.7370	7350	62.2
After 5 min. hold		0.7757	0.9636	0.7757	0.7939	1.0619	0.8225	0.7390	1.0430	0.7420		
Mode of Eathers.												

Mode of Failure:

One web 20" from one end (the full web end) on one outer truss started to deform and buckle when an evenly distributed load of 120 pcs. was applied.

i.e 8400 lbs or 71.186 psf.

A second web 39" from the same end (the full web end) on the same outer truss started to deform and buckle when an evenly distributed load of 126 pcs. was applied i.e. 8820 lbs. or 74.746 psf. The test was concluded at this point.



Oxhebet 26.



GOUVIS

Sht 1 J.N. G. 12250 Date 7/46 Client MEYER

20 GA TRUIS SPAH = 17-3"

DL= 10 PSE LL = 40 PSF SPACING = 24" 0/C

TOP CHOPO: M= . 0551 'K

P= 4.335K

Pau = 4.37 > 4.335 K

BOT CHOPD:

M= 0.0468 K

 $T = 4.365^{k}$

TALL = 6.9 1 > 4.365 OK!

WEB (AT WEAKEST SECTION)

PMAX = 1.2K

Paul= 1.5 × > PMAX OK!

 $\Delta_{\Gamma L} = .579'' = \frac{L}{358} > \frac{L}{240}$ OKI

 $\Delta_{LL} = .463" = \frac{L}{447} > \frac{L}{360}$ okl



Sht 2 J.N. G- 12250 Date 7/96 Client METER

18 GA TRUSS

SPAN = 20'-3"

OL=10PSF LL=40PSF SPACIFF =24" 0/6

TOP CHOPO:

M= .0706 K

P= 5.97 K

PALL = 6.05 x > 5.97 OK!

BOT. CHOPO:

OF PER INSP.

WEB:

PMAX = 1.75K

Paul= 211K >1.75K

ok

Dru = .826" = L = 294 < 240 OK!

 $\Delta u = .661'' = \frac{L}{367} < \frac{L}{360}$ of!



Sht 3 J.N. G- 12250 Date Client

20 GA TRUSS

SPACING = 12" 0/C

$$\frac{(40) \quad L^4}{(80) (17.25)^4} = \frac{(L/360)(12)}{.463}$$

$$\frac{50 (L)^{2}}{100 (17.25)^{2}} = \frac{4.37}{4.34}$$

$$\frac{\frac{1}{2}(50)(L)}{\frac{1}{2}(100)(17.25)} = 1$$

$$L = 34.5'$$



Sht 4
J.N. G- 12250
Date
Client

20 GA TRUSS SPACIFG = 16" 0/C

1)
$$L = \sqrt[3]{\frac{80}{53.3}(6374.6)} = 21.23' \leftarrow GOUEKN$$

2)
$$L = \sqrt{\frac{100}{667}(299.6)} = 22.0'$$

Sht 5 J.N. G- 12250 Date Client

20 GA TRUSS 19.2" O/C



Sht G J.N. G. | 2250 Date Client

18 GA TRUSS SPACIFG = 12" 0/C

 $\frac{(L)^{2}}{2(20.25)^{2}} = \frac{6.05}{5.97}$ $L = \sqrt{(2)(415.6)} = 25.83$

$$l=(2)(20.25)=40.50'$$

LAUOW = 25'-8"



Sht 7
J.N. G- | LZSO
Date
Client

13 GA TRUSS SPACING = 16" 0/c

LALLOW = 23'-4"



Sht B J.N. G- \2250 Date Client

13 GA TRUSS

exhibit 27

<u>QUOTATION</u>

Tel: (310) 949-2446 Toll Free: 800-282-6285 FAX: (310) 942-0624

National Machinery Exchange, Inc.

Wire and Metal Working Machinery
WEST COAST DIVISION
7805 Paramount Blvd., Pico Rivera, CA 90660 (USA)

Darryl Meyer
TRUSTEEL MFG.
18 Vista Encante
San Clemente CA 92672

Date: 08/06/96 Ref#: 28446

Mach: 100194

Tel: 714-285-1004 FAX: 714-285-1369

We are pleased to offer the following for your consideration:

ONE (1) USED
WARCO MOMDEL #SC2-200-54-54E STRAIGHT SIDE DOUBLE CRANK PRESS

 Strokes Per Minute
 33 to 70

 Area of Bed
 54-1/2" x 54"

 Area of Slide
 54" x 54" T-slot

 Windows
 38-3/4" x 10-3/4"

Boslter 54" x 54" x 6" (T-slot)

EQUIPPED WITH:

Air Clutch Air Counter Balance 40 HP Main Motor

Overall Dimensions: 9' x 10' x 15'6"

Weight:

52,000 #

PRICE: \$69,500.00

"If It's Machinery, We Have It!"

THIS QUOTATION IS FOR IMMEDIATE ACCEPTANCE AND SUBJECT TO CHANGE WITHOUT NOTICE. CLERICAL ERRORS ARE SUBJECT TO CORRECTION. DELIVERIES ARE CONTINGENT UPON PRIOR SALE AND DELAYS OCCASIONED BY STRIKES, FIRE, ACCIDENTS OR OTHER CAUSES BEYOND OUR CONTROL. WE WILL NOT BE RESPONSIBLE IF GOODS ORDERED PROVE TO BE AN INFRINGEMENT AGAINST PATENT RIGHTS. SHIPMENT SUBJECT TO BUYERS RISK.

National Machinery Exchange, Inc.

Bob Dordspeed

OUOTATION

Tel: (310) 949-2446 Toll Free: 800-282-6285 FAX: (310) 942-0624

National Machinery Exchange, Inc.

Wire and Metal Working Machinery
WEST COAST DIVISION
7805 Paramount Blvd., Pico Rivera, CA 90660 (USA)

Darryl Meyer TRUSTEEL MFG. 18 Vista Encante San Clemente CA 92672 Date: 08/06/96 Ref#: 28445

Mach: 101655

Tel: 714-285-1004 FAX: 714-285-1369

We are pleased to offer the following for your consideration:

ONE (1) USED
BLISS MODEL #S2-150-60-36 2-POINT STRAIGHT SIDE DOUBLE CRANK PRESS

TIE ROD FRAME ---- SINGLE BACK GEARED

Rated Capacity	150 Tons
Stroke of slide	10"
Shutheight	
Ram Adjustment	8"
Ram Area	60" x 36"
Ram Plate	60" x 36" x 4"H T-slotted
Bolster(1-r x f-b x h)	60" x 36" x 2-1/2"
Side Frame Opening(1-r x high)	19" x 15"
Strokes per Minute	35
Width between Uprights	

Air Clutch on Flywheel 15 HP 3/220-440/60 Motor Flywheel V-Belt one-shot Lubrication System (2) Air Cushions 2,5 tons w/5" travel Air Counterbalance Palm Button Controls Motor mounted on top

PRICE: \$49,500.00

"If It's Machinery, We Have It!"

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National Machinery Exchange, Inc.

Bob Doodspeed

Tel: (310) 949-2446 Toll Free: 800-282-6285 FAX: (310) 942-0624

National Machinery Exchange, Inc.

Wire and Metal Working Machinery WEST COAST DIVISION 7805 Paramount Blvd., Pico Rivera, CA 90660 (USA)

Darryl Meyer TRUSTEEL MFG. 18 Vista Encante San Clemente CA 92672 Date: 08/06/96 Ref#: 28444

Mach: 57716

Tel: 714-285-1004 FAX: 714-285-1369

We are pleased to offer the following for your consideration:

ONE (1) USED BLISS MODEL #6-60W STRAIGHT SIDE DOUBLE CRANK TIE ROD DESIGN PRESS

GEARED.....DOUBLE BACK STROKE OF SLIDE.....8" SHUTHEIGHT.....18-1/2" ADJUSTMENT.....3"

RAM AREA.....54-1/2" L-R X 34" F-B

SIDE FRAME OPENINGS......12" L-R X 10" H

DISTANCE BETWEEN UPRIGHTS......61" SHAFT.....5-3/4" SPEEDS: STROKES PER MINUTE......20

EQUIPPED WITH:

AIR CLUTCH TWIN END DRIVE FLYWHEEL "V" BELT AIR COUNTERBALANCE TO RAM AIR CUSHION IN BED MARQUETTE TYPE 18" DIAMETER X 6" STROKE POWER RAM ADJUSTMENT 15 HP 3/60/220-440 (1755 RPM) MOTOR

PRICE: \$24,500.00

"If It's Machinery, We Have It!"

THIS QUOYATION IS FOR IMMEDIATE ACCEPTANCE AND SUBJECT TO CHANGE WITHOUT NOTICE. CLERICAL ERRORS ARE SUBJECT TO CORRECTION. DELIVERIES ARE CONTINGENT UPON PRIOR SALE AND DELAYS OCCASIONED BY STRIKES, FIRE, ACCIDENTS OR OTHER CAUSES BEYOND OUR CONTROL. WE WILL NOT BE RESPONSIBLE IF GOODS ORDERED PROVE TO BE AN INFRINGEMENT AGAINST PATENT RIGHTS. SHIPMENT SUBJECT TO BUYERS RISK.

National Machinery Exchange, Inc.

OUOTATION

Tel: (310) 949-2446 Toll Free: 800-282-6285 FAX: (310) 942-0624

National Machinery Exchange, Inc.

Wire and Metal Working Machinery
WEST COAST DIVISION
7805 Paramount Blvd., Pico Rivera, CA 90660 (USA)

Darryl Meyer TRUSTEEL MFG. 18 Vista Encante san Clemente CA 92672 Date: 08/06/96 Ref#: 28442

Vera. Sodar

Mach: 58335

Tel: 714-285-1004 FAX: 714-285-1369

We are pleased to offer the following for your consideration:

ONE (1) USED
BLISS-TOLEDO MODEL #93-1/2 STRAIGHT SIDE DOUBLE CRANK PRESS

EQUIPPED WITH:

AIR CLUTCH
AIR COUNTERBALANCE TO RAM
ONE SHOT LUBE SYSTEM
TWIN END DRIVE
AC MOTOR AND CONTROLS

PRICE: \$17,000.00

"If It's Machinery, We Have It!"

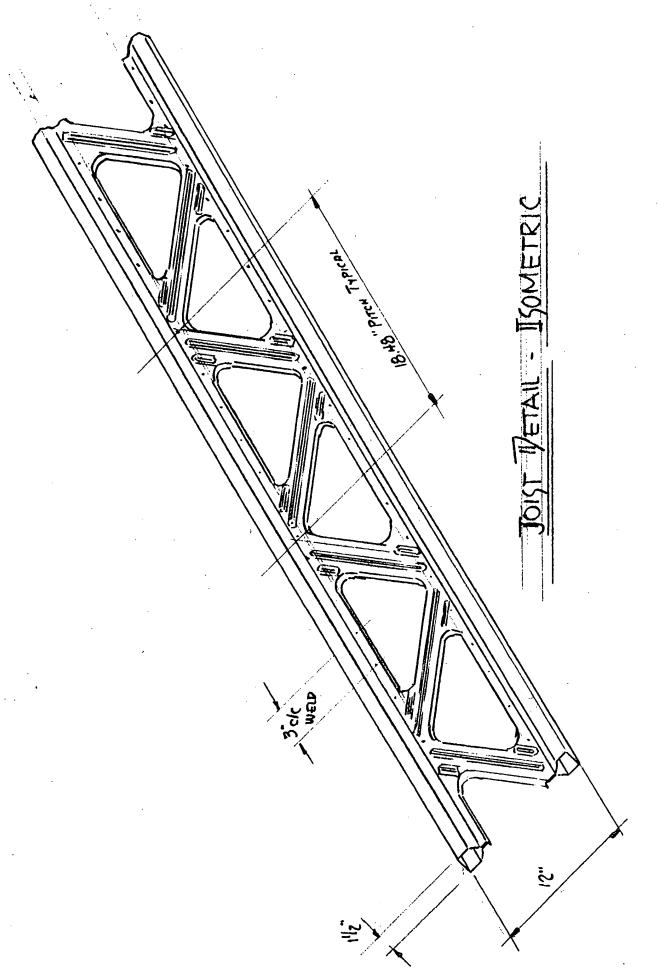
THIS QUOTATION IS FOR IMMEDIATE ACCEPTANCE AND SUBJECT TO CHANGE WITHOUT NOTICE. CLERICAL ERRORS ARE SUBJECT TO CORRECTION. DELIVERIES ARE CONTINGENT UPON PRIOR SALE AND DELAYS OCCASIONED BY STRIKES, FIRE, ACCIDENTS OR OTHER CAUSES BEYOND OUR CONTROL. WE WILL NOT BE RESPONSIBLE IF GOODS ORDERED PROVE TO BE AN INFRINGEMENT AGAINST PATENT RIGHTS. SHIPMENT SUBJECT TO BUYERS RISK.

National Machinery Exchange, Inc.

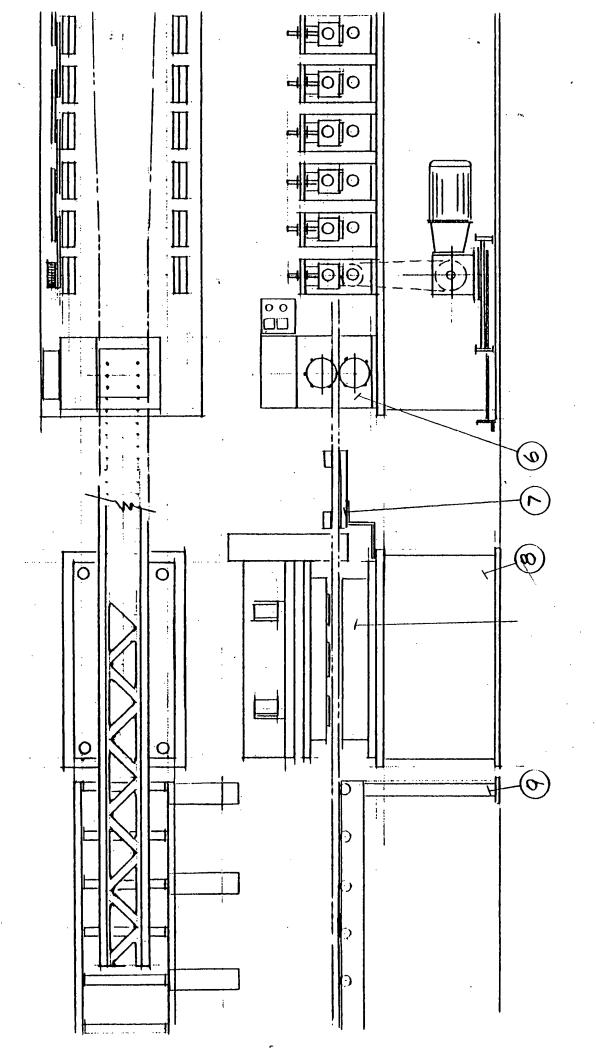
Bob Doodspad

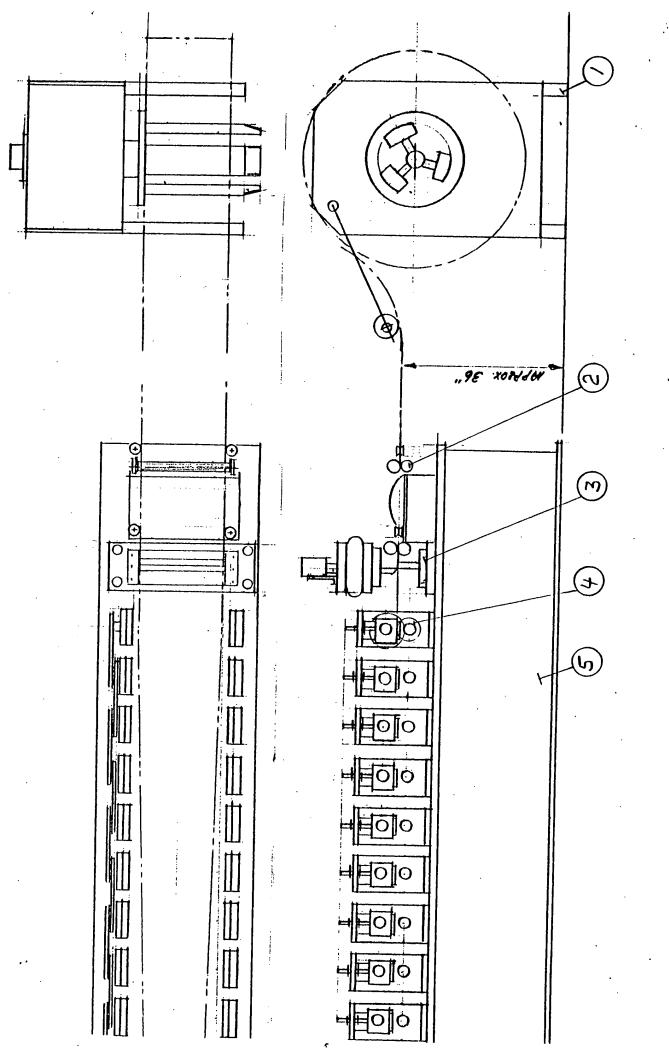
exhibit 28

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	ENGINI 2697 S. Hallada (714) 979-5940	ay St., Santa Ai FAX (7	na, CA 92705 /14) 979-1617) 1019)	79 - 76	580	
1-LINE	Name of Part ROL		L JOIST	Due: 26 Mr. Tax: YES	Person DARRE		Customer: TRUSS	TEEL
Part #			MACHINE			1004		
MAL STEEL!	18 + 2064.	x21.5"	K COIL		P.O.#:			
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•-	(3)	PREPL	INCH PI					
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AL ENGINEERING, INC. 2697 So. Halladay St. Santa Ana, CA 92705 (714) 979-5940





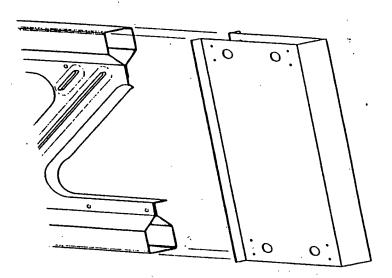
AL ENGINEERING, INC. 2697 So. Halladay St. Santa Ana, CA 92705 (714) 979-5940



0

ENGINEERING, INC. 2697 S. Halladay St., Santa Ana, CA 92705 (714) 979-5940 • FAX (714) 979-1617

		•	Due: 8 WKS			Customer: TRUS	
Part #	TRUSS ENOS" Process TOOLING			Phone: 7/4 FAX: 4	ARKEGE METER	STEEL	



1. TO DIE DESIGN:

a BLANK DIE. (PIERCE + CUTOFF)

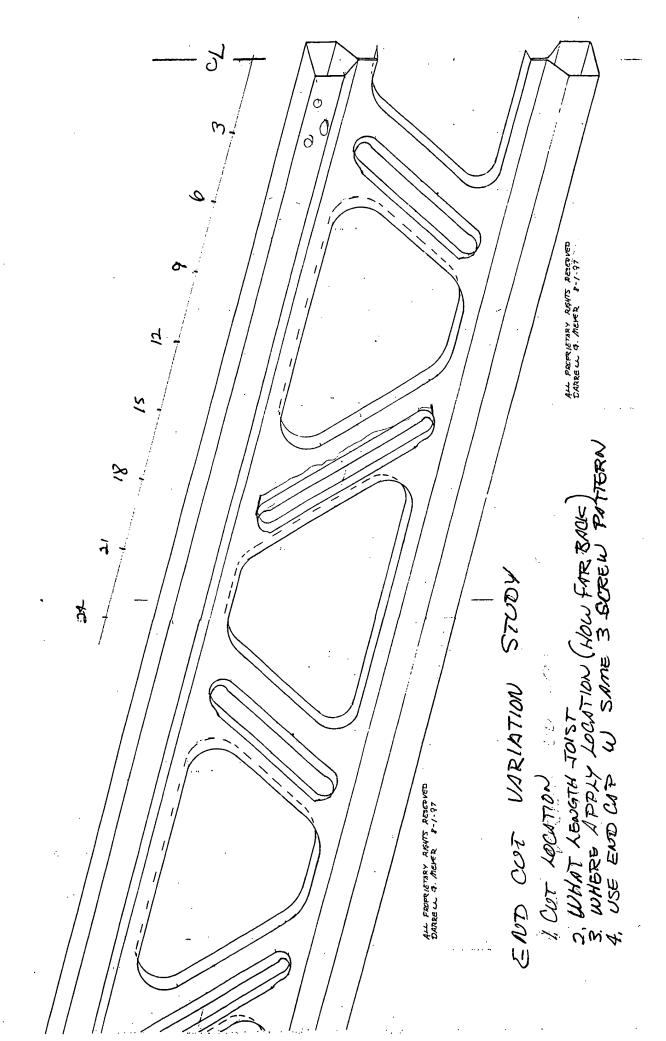
f. DBL. FORM DIE.

NOTES:

F.O.B.

Oxhubit 29

NOTE: REVERSING FLANGE DIRECTION - TOO COMPLEX IN DIE DESIGN



ALL PROPRETARY RIGHTS RESERVED DARRELL 9. MEMER 18-1-97

Oxhibit 30

QUOTATION

National Machinery Exchange, Inc.

Wire and Metal Working Machinery WEST COAST DIVISION 7805 Paramount Blvd., Pico Rivera, CA 90660 (USA) Toll Free: 800-282-6285 FAX: (310) 942-0624

Tel: (310) 949-2446

Darryl Meyer TRUSTEEL MFG. 18 Vista Encante San Clemente CA 92672 Date: 01/07/98 Ref#: 41392

Mach: 101816

Tel: 714-285-1004 FAX: 714-285-1369

we are pleased to offer the following for your consideration:

ONE (1) USED

YODER 15 STAND ROLL FORMER

AREOR DIAMETER MAXIMUM WIDTH BETWEEN HOUSINGS 27-1/2" EORIZONTAL DISTANCE BETWEEN CENTERS 20-1/2" MAXIMUM VERTICAL DISTANCE BETWEEN CENTERS 10.8"

EQUIPPED WITH:

ADJUSTABLE ENTRY EDGE GUIDE SIDE PLATES MOUNTED ON IDLER ROLL STAND EDGE GUIDE ROLL STAND ADJUSTED VIA HAND CRANK SCREW OUTBOARD HOUSING BASES BOLTED TO T-SLOTS IN MACHINE BED TO HOLD THEM INTO POSITION DIRECTION OF FLOW: LEFT TO RIGHT 40 KW 3/230-380/50 (1450 RPM) 133/77 AMP MOTOR ELECTRIC BRAKE

PRICE: \$62,500.00

"If It's Machinery, We Have It!"

THIS QUOTATION IS FOR IMMEDIATE ACCEPTANCE AND SUBJECT TO CHANGE WITHOUT NOTICE. CLERICAL ERRORS ARE SUBJECT TO CORRECTION. DELIVERIES ARE CONTINGENT UPON PRIOR SALE AND DELAYS OCCASIONED BY STRIKES, FIRE, ACCIDENTS OF OTHER CAUSES BEYOND OUR CONTROL. WE WILL NOT BE RESPONSIBLE IF GOODS ORDERED PROVE TO BE AN INFRINGEMENT AGAINST PATENT RIGHTS. SHIPMENT SUBJECT TO BUYERS RISK.

National Machinery Exchange, Inc.

OUOTATION

NATL MACH'Y WEST

Tel: (310) 949-2446 Toll Free: 800-282-6285 FAX: (310) 942-0624

National Machinery Exchange, Inc.

Wire and Metal Working Machinery
WEST COAST DIVISION 7805 Paramount Blvd., Pico Rivera, CA 90660 (USA)

> Darryl Meyer TRUSTEEL MFG. 18 Vista Encante San Clemente CA 92672

Date: 01/07/98 Ref#: 41391

Mach: 102512

Tel: 714-285-1004 FAX: 714-285-1369

We are pleased to offer the following for your consideration:

ONE (1) USED

LOCKFORMER 12 STAND ROLL FORMER

ARBOR DIAMETER 3" HORIZONTAL CENTERLINE DISTANCE 20"

VERTICAL CENTERLINE DISTANCE 7" MINIMUM

DISTANCE BETWEEN HOUSINGS 30"

O.A. DIMENSIONS 24"3" LR X 5'7" FB X 4'11" HIGH

EQUIPPED WITH:

RIGHT TO LEFT ENTRY FLOW ENTRY EDGE GUIDE MOTOR

PRICE: \$42,500.00

"If It's Machinery, We Have It!"

THIS QUOTATION IS FOR IMMEDIATE ACCEPTANCE AND SUBJECT TO CHANGE WITHOUT NOTICE. CLERICAL ERRORS ARE SUBJECT TO CORRECTION. DELIVERIES ARE CONTINGENT UPON PRIOR SALE AND DELAYS OCCASIONED BY STRIKES, FIRE, ACCIDENTS OR OTHER CAUSES BEYOND OUR CONTROL. WE WILL NOT BE RESPONSIBLE IF GOODS ORDERED PROVE TO BE AN INFRINGEMENT AGAINST PATENT RIGHTS. SHIPMENT SUBJECT TO BUYERS RISK.

National Machinery Exchange, Inc.

OUOTATION

Tel: (310) 949-2446 Toll Free: 800-282-6285 FAX: (310) 942-0624

National Machinery Exchange, Inc.

Wire and Metal Working Machinery
WEST COAST DIVISION
7805 Paramount Blvd., Pico Rivera, CA 90660 (USA)

Darryl Meyer
TRUSTEEL MFG.
18 Vista Encante
san Clemente CA 92672

Date: 01/07/98 Ref#: 41390

Mach: 103332

Tel: 714-285-1004 FAX: 714-285-1369

We are pleased to offer the following for your consideration:

ONE (1) USED

McKAY 10 STAND ROLL FORMER

PRICE: \$72,500.00

"If It's Machinery, We Have It!"

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National Machinery Exchange, Inc.

Bol Goodgeed

Oshebit 31



January 8, 1998

Mr. Darrell Meyer Steelworks 1801 Parkcourt Building E 200 Santa Ana, CA 92701

Dear Mr. Meyer,

The first to build a fast and reliable flying hydraulic punch and cutoff; American Machine & Rollform Tech, Inc. has continued to be an innovator in hydraulic technology in the rollforming industry for over 15 years. In line with that progress we are ready to introduce into the market place our complete rollforming system to include the high performance American Machine rollformer.

While the "flying" press allows you to maintain a constant line speed without stopping to punch or cut your product, the rollformer with its double enveloping worm and worm gear provides high shock resistance for heavy load starting and stopping. By providing extra torque capacity, low backlash, and increased durability, this design will provide more years of higher productivity than straight worm gear designs.

One of the key reasons American Machine has been a leader in the rollform industry is your production output will remain consistent, precise, and predictable, delivering line speeds in excess of 300 FPM. As part of The Bradbury Group of companies we offer you our specific and unique set of technical skills and experience along with the united capabilities of all our companies within the group.

We obviously want an opportunity to earn your business and trust that you will consider us as a serious and viable option for future equipment needs. I look forward to talking with you regarding our equipment specifications.

Sincerely,

Robert P. Booth Sales Coordinator

Enclosures

AMERICAN MACHINE & ROLLFORM TECH, INC.

J. B. Leahy

@ ATLANTA

2771 Pence Loop SE
Salem OR 97302
503-588-2638 Fax 503-588-4029
E-mail: jbleah@arnericanmachine.com

THE BRADBURY GROUP

Oxhibit 32



1801 E. Parkcourt Place Building E, Suite 200 Santa Ana, CA 92701 (714) 285-1004 Fax (714) 285-1369

March 25, 1998

Mr. Robert Booth American Machine & Roll Form 2771 Pence Loop SE Salem, OR 97302

Re: Steel I Joist

Dear Robert,

The Steel I Joist manufacturing line should incorporate these general specifications for the product with your expertise leading the way to determine the most efficient way to achieve our goals.

SPECIFICATIONS:

- Finished Dimensions 12" High and 1 1/2" Wide
- Steel Grade 50 KSI (+) Zincalume
- Both 18 Gauge and 20 Gauge capacity
- Material width 20.5" (Plus or Minus)
- Pentagon Shaped Chord Sections
- Mechanical Clinch-Fasten to close Chords
- 12" center to center dimension of openings in triangle
- Bend flanges to achieve stiffness in center section Continuous
- Bend flanges in reverse in slots (If possible)

The roll form line and ancillary stations may be positioned to achieve the following objectives:

- Continuous lengths to 40 feet
- Cut to order increments of 1 foot
- "Factory" end / start of stamped openings
- Mechanical Clinch-Fastener to close Chords may be Wheel Type (Hill Mfg. or Eckold) or Flying Tog-L-Loc (BTM)

- Roll-Form Line probable specs:
 - a. 2 1/2" diameter shafts
 - b. 24" stand clearance
 - c. 14 16 stands
- Uncoiler
 - a. Single w rail
 - b. Double
- Welder Coil Ends
- Stacker Accumulator
- On-Line stamp openings / Form flange hydraulic
- "Alternative" Off-Line stamp / Flange separate feed Progressive punch and die

Decisions on machinery locations to best complete the following steps:

- Cut to Length 1 foot increments
 - a. Prior to entry
 - b. Shear outer 1/3 each side prior to entry, center section after pentagon Flying cut-off
 - c. After forming and clinching
- Punch triangular opening
- Punch or shear diagonal slots
- Form flanges Triangle
- Form flanges Slot

I look forward to your recommendations, proposal and a long relationship.

Sincerely, Steelworks

Darrell G. Meyer

DGM/lw

Oschubet 33



1801 E. Parkcourt Place Building E, Suite 200 Santa Ana, CA 92701 (714) 285-1004 Fax (714) 285-1369

1841 C. C. Abbout State Beddae C. Seri, Law

Sa LANGLAR LANGLINE

714 35 1 64

Pay (Tile) (27-17-49

April 6, 1998

Mr. Al Strecker, Sales Manager The Bradbury Company Air Industrial Park Moundridge, KS 67107

RE: Steel I Joist Rollform Line

Building 5, Sales 100

Dear Mr. Strecker,

1714-185-186

Per our conversation of Friday, April 3, 1998, I enclose preliminary drawing for the manufacture or a residential floor joist. These are the same drawings furnished to Mr. Dan Lovelace and Mr. Robert Booth at our meeting in their offices March, 25, wherein we discussed various methods of production leading to a proposal to build a Rollform Line.

We recognize you as the experts in roll form design, but several options arise as where to best perform functions such as:

- Cut to length
- Cut openings and slot
- Bend flanges, preferably up and down
 - a) On line, after closure, on fly
 - b) Off line, progressive punch and die
- Handling of product flow after roll form (under either condition)

I also enclose a Non-Disclosure Agreement, the execution of which I would appreciate. I hereby acknowledge assurance to you of mutual confidentiality on potential concepts developed for fabrication of this product.

My original design was discussed with Richard Pearson in 1996 and Bradbury generated a proposal. Further engineering and subsequent prototype tests, meetings with I. C. B. O. (International Congress of Building Officials) and concerns about resistance spot welding have led to the current design and specifications.

ROB - FAX 4029 503 588 - 4029 THU 4-9 2100 Mechanically fastening/closing of the pentagon shaped chords on the roll form line with a system that maintains consistent quality that can be monitored and inspected is a prime concern. Two companies have the experience and capability to provide a rotary unit, Hill Engineering and Eckold. Dan and Rob suggested I correspond further with Thomas Grossman and I enclose a copy of my letter to him.

We would welcome your critique of the joist and the best way to manufacture same. I want to be able to obtain an I.C.B.O. number which establishes engineering performance standards that are uniformally recognized. Hopefully, we will do it so well, we will stifle potential knock-offs.

Multiple plants or licensing arrangements are the long range goal with the original plant to be operated here is southern California.

I thank you, Dan and Bob for an opportunity to meet in person at your factory, introducing the H L stud line. I have scheduled a flight and plan to be in your facility Wednesday, April 22, 1998, at 8:30 AM.

I look forward to your initial comments following receipt of this package, developing the system and, of course, meeting all of you on the 22nd.

Respectfully,

Steelworks

Darrell G. Meyer

DGM/lsw

Enclosures

cc: Dan Lovelace, Robert Booth

American Machine

Oxhebit 34



1801 E. Parkcourt Place Building E, Suite 200 Santa Ana, CA 92701 (714) 285-1004 Fax (714) 285-1369

April 6, 1998

Mr. Thomas Grossman Eckold A G CH - 7203 Trimmis Schweiz, Switzerland

RE: Steel I Joist / Mechanical Joining

Dear Mr. Grossman,

In Atlanta, this past October, we discussed the feasibility of your firm providing a Rotary / Wheel Clinching Machine to be installed on a Roll Form line.

Enclosed is a preliminary drawing showing the cross section of our floor joist, 12" \times 1 1/2" with basic specifications.

I am working with American Machine and Bradbury Company on the complete Roll Form Line. Their addresses and phone numbers are listed below.

The fastening system must be able to meet certain engineered load standards to ultimately satisfy I. C. B. O. (International Congress of Building Officials) and allow some method of periodic sampling and inspection.

Multiple plants or licensing arrangements are the long range goal with the original line to be operated here in southern California.

As soon as possible, review our request and advise feasibility, general configuration and dimensions.

I welcome your comments and also feel free to contact the aforementioned companies on the team. Your confidentiality is appreciated.

Steelworks

Darrell G. Meyer

DGM/lw Enclosures

cc: Craig Leber, USA Agent

Oxhubit 35

Tel: (416) 264-5790 Fox:(416) 264-5632



3233 Eglinton Avenue East Suite 1109 Toronto, Ontario MIJ 3N6

Mr. Meyer

Following is a quotation for an uncoiler for your new roll forming project.

I have built many uncoilers for Kent Corporation in the past and now have an agreement to build both Kent's uncoiler as well as my own design which Kent will often purchase when their own design is oversized for a certain application. In this case I have spoken with Mark Costello at Kent Corporation and he had mentioned that he quoted an uncoiler and coil end welder for your new roll form project with American Machine.

Mark has said that you may buy the entry and coil handing equipment separate to save a little money. Mark also agrees that his uncoiler that he quoted may be way oversized for this application. Kent's uncoilers are for filling into high speed accumulators for the tube mill industry and can handle speed up to 1,800 feet per minute. The uncoiler I have quoted can also be used for accumulators and with the proper brake can handle 1,000 feet per minute. However, by buying direct from Sim-Vision you can save money. We have an excellent exchange rate for US currency and, therefore, we can offer an excellent product at a very competitive price. Please see the quotation.

Kent Corporation has supplied coil end welders to me in the past for entry lines I have built at previous companies. Kent offers the best coil end welding products available. We have had little to no service required in the years I have purchased their products.

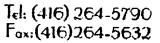
I hope we can all work together on this project and many others in the future. I am sure you will be more than happy with our equipment.

Note: We can also quote the straightener and incorporate the Kent coil end welder into our entry at no additional cost. Please call if interested.

Yours very truly,

Kevin Simpson

President





3233 Eglinton Avenue East. Suite 1109 Toronto, Ontario MIJ 3196

QUOTATION NO. 126-98

April 17, 1998

Mr. Darrell Meyer TRUSSTEEL 3822 East La Palma Ave. Anaheim, CA. 92807 Fax: (714) 630-0880 Phone: (714) 630-9620

SUBJECT: 10,000 lb. HYDRAULIC DOUBLE UNCOILER

Dear Darrell, We are pleased to offer the following

ITEM #1 10,000 LBS HYDRAULIC DOUBLE UNCOILER

MODEL # 10K-D-HYD
AS PER SPECIFICATION SHEET #11050

PRICE \$ 38,950.00

OPTIONAL

SHOCK ABSORBERS

PRICE \$ 2,600.00

NOT INCLUDING:

SHIPPING, INSTALLATION MACHINE AND ELECTRICAL GUARDING SET-UP AND ELECTRICAL INTERGRATION

Prices are quoted in US \$ dollars

The attached Condition of Sale Bulletin #5000 form is a part of our proposal

E.Q.B.:

SIM-VISION, Toronto, Ontario

Terms and Condition

25% Downpayment with P.O.

25% After engineering approval

25% Upon 50% completion

15% Before shipping

10% Net 30 days

Delivery

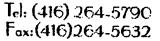
Based on today's workload is approx. 14-16 weeks.

This quotation is valid for 60 days Looking forward to hearing from you.

Yours very truly,

Kevin Simpson

President





3233 Eglinton Avenue East Suite 1109 Toronto, Ontario M1J 3N6

UNCOILER

SPECIFICATION SHEET # 11050 6000 LB. DOUBLE

Model	- 10K-D-HYD
Number of Mandrels	- 2
Capacity	- 10,000LBS/SIDE
Maximum Outside Diameter	- 60"
Maximum Width	- 24"
Inside Diameter Expansion	- 17 ½" - 20 ½"
Expansion Type	- WEDGE
Expansion Power	- MANUAL
Number of Drum Segments	- 4
Rotation	- MANUAL
Rotation Locking	- HYD WEDGE TYPE
Hand of Operation	- T.B.A.
Power Supply (Control)	- T.B.A.
Loading Method	- C HOOK / LIFT TRUCK
Colour	- T.B.A.
Brake	- AIR DRAG 250 FPM MAX
Feed-Up Drive	- NOT REQUIRED
Hold-Down Roll	- NOT REQUIRED

SIM-VISION UNCOILERS

Standard Features

- 3000 lb. uncoilers have a link type mandrel
- 6000 lb. and 10000 ib. uncoilers have a wedge type mandrel
- Maximum air pressure required is 80 p.s.i.
- · Pneumatic disc brake with air regulator
- (2) two coil keepers per mandrel
- Manual expansion, with (1) one adjusting wrench
- 60" full diameter backing plate
- (4) four leaf mandrels
- 3" sub-base on all double mandrel uncoilers
- Heavy duty, all steel welded construction
- Timken bearings
- Solid wedge locking on double uncoilers
- Standard colour are sky blue and safety orange
- 3 h.p. bydraulie unit with all hydraulie expansion uncollers (max. 800 psi)
- Individual electrics (stand alone operating uncollers)

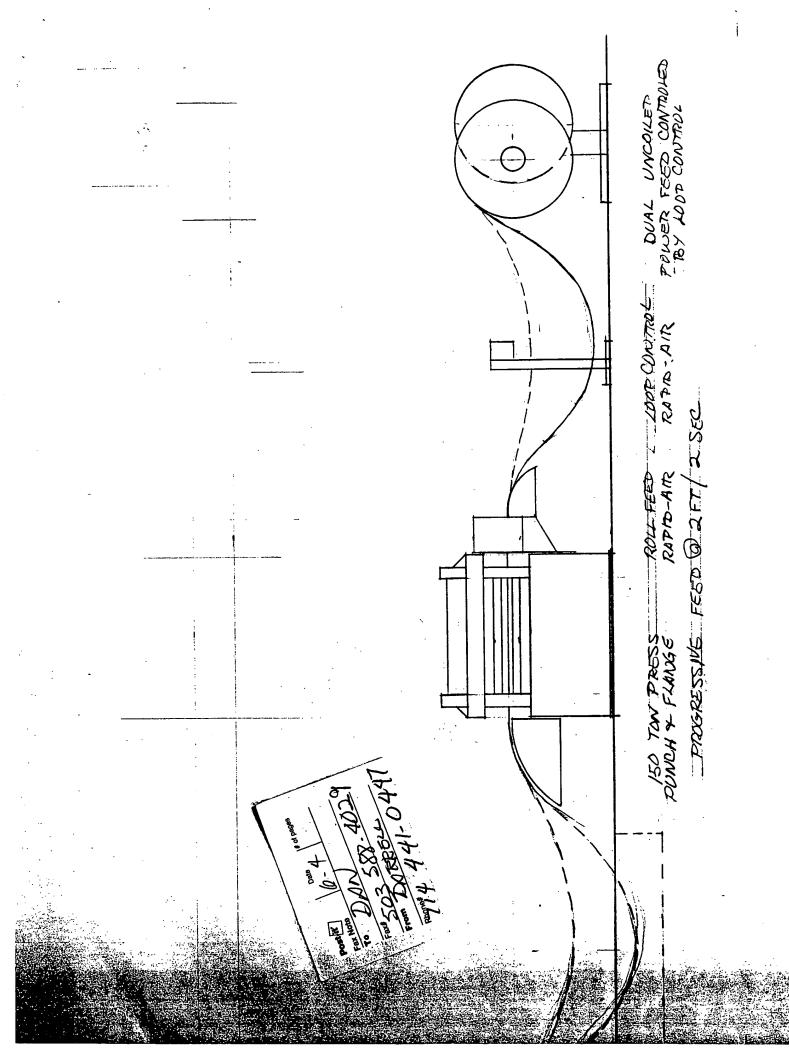
Options

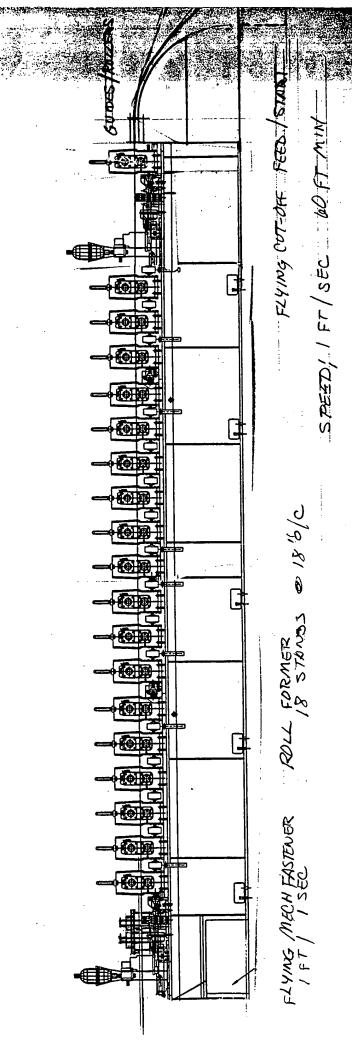
- 12" powered sideways travel
- 72" full backing plates
- Non-powered pneumatic hold-down (free wheel only)
- Hydraulic hold-down free wheel only (top of uncoller / floor mounted)
- · Hydraulic hold-down with feed-up roll (top of uncoller / floor mounted)
- Bolt on pads (four required) (16"-20"-24" inside diameters)
- Outboard coil retainer (60"-72" diameter coils) (bydraulic / electric)
- Electric loop control (driven uncollers only)
- · Over-running clutch (driven uncoilers only)
- 180 degree powered rotation (double uncoiler only)
- Shock absorber (two required) (double uncoiler only)
- High speed package (300-1000 ft/min), oversized air brake, shock absorbers and dual air pressure brake control
- Special colour paint

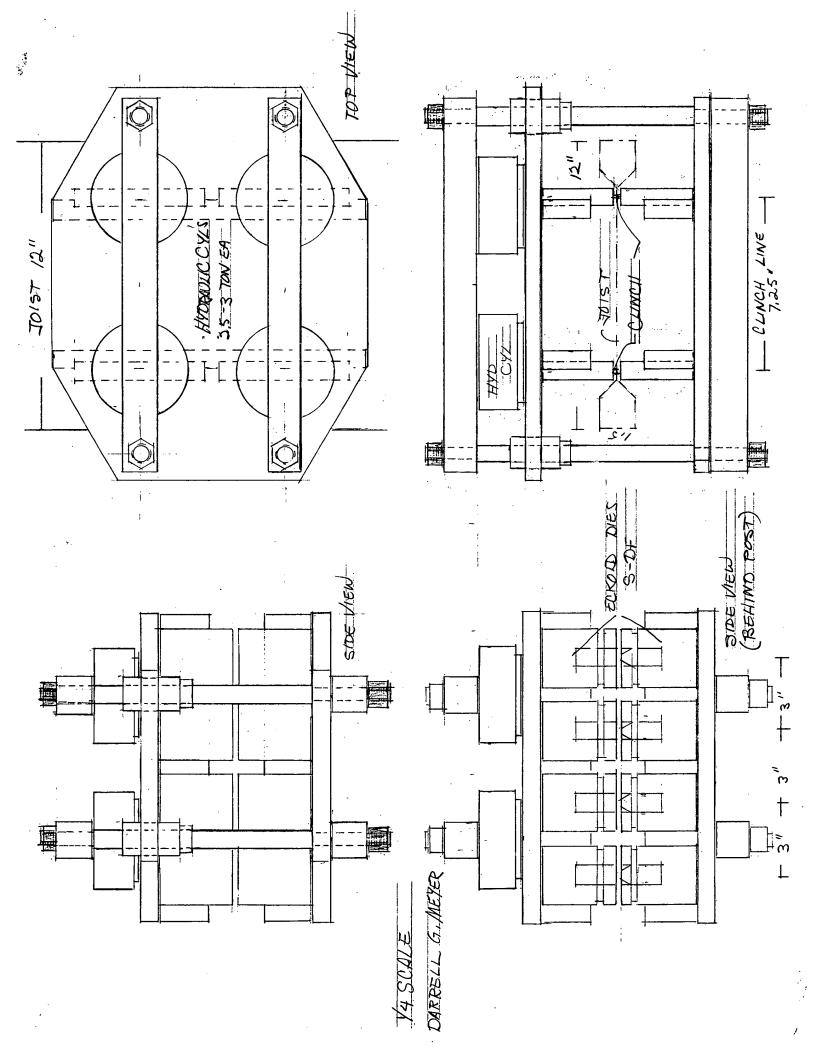
Driven Uncoiler Options

- Hydraulic feed-up (3-5 fpm)
- Electric feed-up (3-5 fpm)
- Hydraulic full time drive (0-100 fpm)
 A.C.-V.F. full time drive (0-100 fpm)
- D.C. full time drive (0-100 fpm)
- Jog forward and jog reverse controls
- Electrical control pendent

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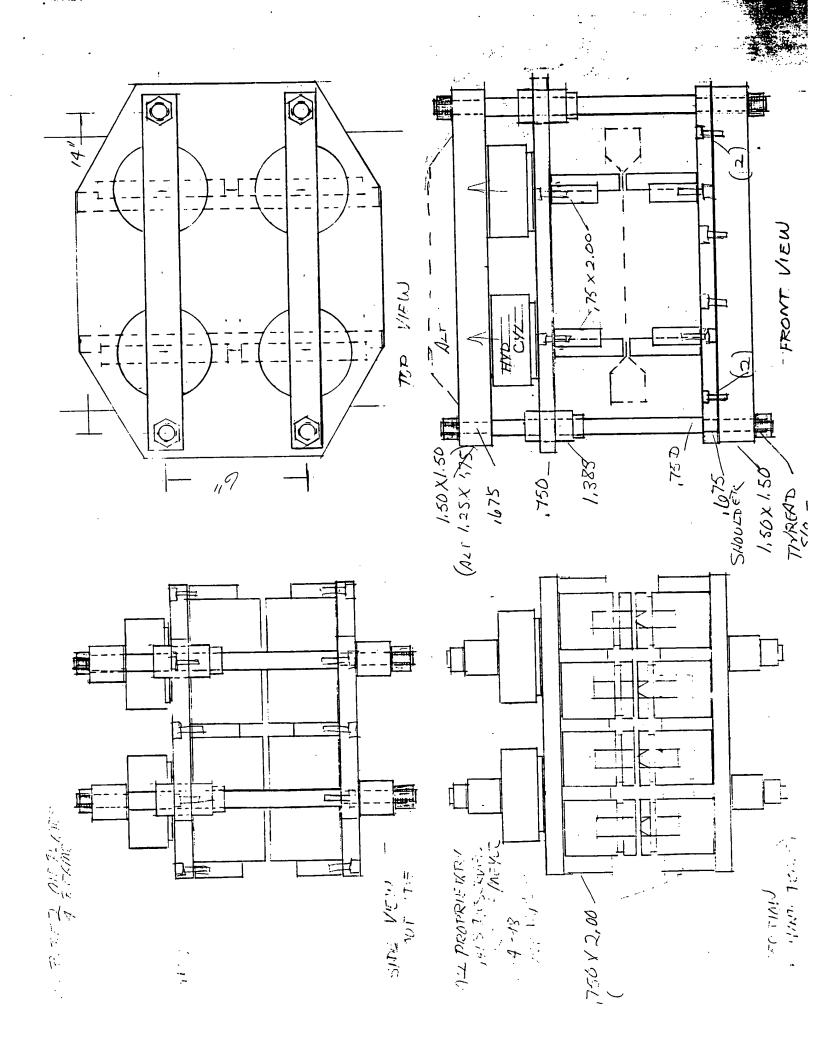


exhibit 37

OUOTATION

National Machinery Exchange, Inc.

Wire and Metal Working Machinery
WEST COAST DIVISION
7805 Paramount Blvd., Pico Rivera, CA 90660 (USA)

Tel: (562) 949-2446 Toll Free: 800-282-6285 FAX: (562) 942-0624 E-mail: nmachine@aimcomm.com

Date: 07/13/98 Ref#: 47236

Mach: 103754

Tel: 714-441-0447 FAX: 714-441-0947

We are pleased to offer the following for your consideration:

ONE (1) USED

Darrell Meyer

3822 East La Palma Anaheim CA 92807

STEEL WORKS

18 STAND, YODER #M2-1/2 ROLL FORMER

SPECIFICATIONS: -

Previously used for construction panels

Hand of Operation: Left to Right Shaft Diameter: 3.250"

Keyway: 3/4" W x 9/16" Thick

Roll Space: 38"

Vertical Centers, (Manual Individual Micrometer Adjustment): 5-3/4" to 9"

Horizontal Centers: 18"

Base to Center Line of Bottom Shaft: 8-1/2"

Pass-Line: 38" - Approximate

Equal Geared

EQUIPPED WITH:-

Push-Button Console and Controls
(1) Box of Miscellaneous Tooling (List Available Upon Request)
Currently Tooled for Construction Paneling

"If It's Machinery, We Have It!"

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National Machinery Exchange, Inc.

QUOTATION

National Machinery Exchange, Inc.

Wire and Metal Working Machinery
WEST COAST DIVISION
7805 Paramount Blvd., Pico Rivera, CA 90660 (USA)

Tel: (562) 949-2446 Toll Free: 800-282-6285 FAX: (562) 942-0624

E-mail: nmachine@aimcomm.com

Darrell Meyer STEEL WORKS 3822 East La Palma Anaheim CA 92807 Date: 07/13/98 Ref#: 47236

Mach: 103754

Tel: 714-441-0447 FAX: 714-441-0947

PAGE 2

MOTOR DATA: -

40 HP, G.E., 550, 1775 RPM 1 HP Boston, 575/1725 RPM

OVERALL DIMENSIONS:- 8'W x 33'6"L x 6'6"H
WEIGHT:- 38,550# Approximate

CONDITION: - Excellent

*** PHOTOS AVAILABLE ***

PRICE: \$89,500.00

"If It's Machinery, We Have It!"

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National Machinery Exchange, Inc.

Wire and Metal Working Machinery
WEST COAST DIVISION
7805 Paramount Blvd., Pico Rivera, CA 90660 (USA)

Tel: (562) 949-2446
Toll Frees 800-282-6285
FAX: (562) 942-0624
E-mail: nmachine@aimcomm.com

Darrell Meyer STEEL WORKS 3822 East La Palma Anaheim CA 92807 Date: 07/13/98 Ref#: 47234

Mach: 102129

Tel: 714-441-0447 FAX: 714-441-0947

We are pleased to offer the following for your consideration:

ONE (1) USED

YODER 11 STAND ROLL FORMER

11 Stands on a 12 Stand Base Unequal Gearing: Gear Driven Outboard Type - Right to Left Feed

 haft r meter
 3"

 Spindle Key Size
 3/4"

 Roll Space
 30"

 Roll Diameter
 10" Maximum

 Vertical Centers
 5" to 10"

 Horizontal Centers
 18"

 Center of Lower Roll to Base
 8.5"

 Height of Base
 24"

 Speed (Approx.)
 75 FPM

Coolant Pump & Motor 230/460/3/60

Main Motor 50 HP 870 RPM 550/3/60

Equipped with:

Powered Entry Rolls
Powered Exit Rolls
Entry Guide & Exit Guide
Micrometer Screw - Vertical Adjustment
In-Base Coolant Reservoir
Individual Coolant Nozzles
Gusher 1/2 HP 3450 RPM

Weight (approx.) 20,000 Lbs.
Overall Dim. <est> 285" 1-r x 77" f-b x 57

PRICE: \$54,500.00

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National Machinery Exchange, Inc.

QUOTATION

National Machinery Exchange, Inc.

Wire and Metal Working Machinery
WEST COAST DIVISION
7805 Paramount Blvd., Pico Rivera, CA 90660 (USA)

Tel: (562) 949-2446
Toll Free: 800-282-6285
FAX: (562) 942-0624
E-mail: nmachine@aimcomm.com

800 631-4470 BOTE DWYER

Darrell Meyer STEEL WORKS 3822 East La Palma Anaheim CA 92807 Date: 07/13/98 Ref#: 47235

Mach: 101816

Tel: 714-441-0447 FAX: 714-441-0947

We are pleased to offer the following for your consideration:

ONE (1) USED

YODER 15 STAND ROLL FORMER

EQUIPPED WITH:

ADJUSTABLE ENTRY EDGE GUIDE SIDE PLATES

MOUNTED ON IDLER ROLL STAND

EDGE GUIDE ROLL STAND ADJUSTED VIA HAND

CRANK SCREW

OUTBOARD HOUSING BASES BOLTED TO T-SLOTS IN MACHINE BED TO HOLD THEM INTO POSITION

DIRECTION OF FLOW: LEFT TO RIGHT

40 KW 3/230-380/50 (1450 RPM) 133/77 AMP MOTOR

ELECTRIC BRAKE

PRICE: \$59,500.00

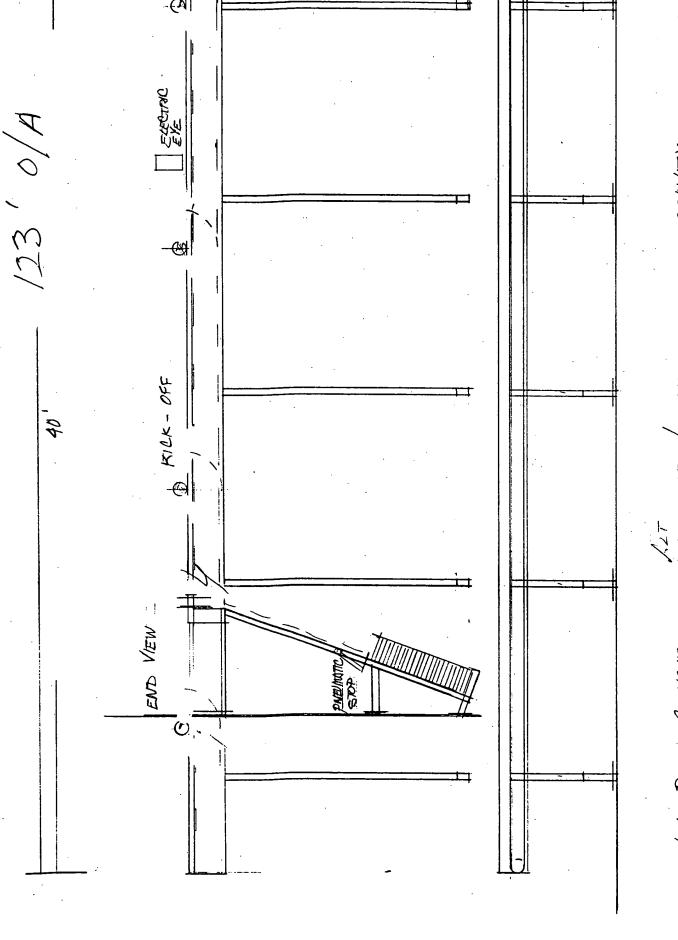
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"If It's Machinery, We Have It!"

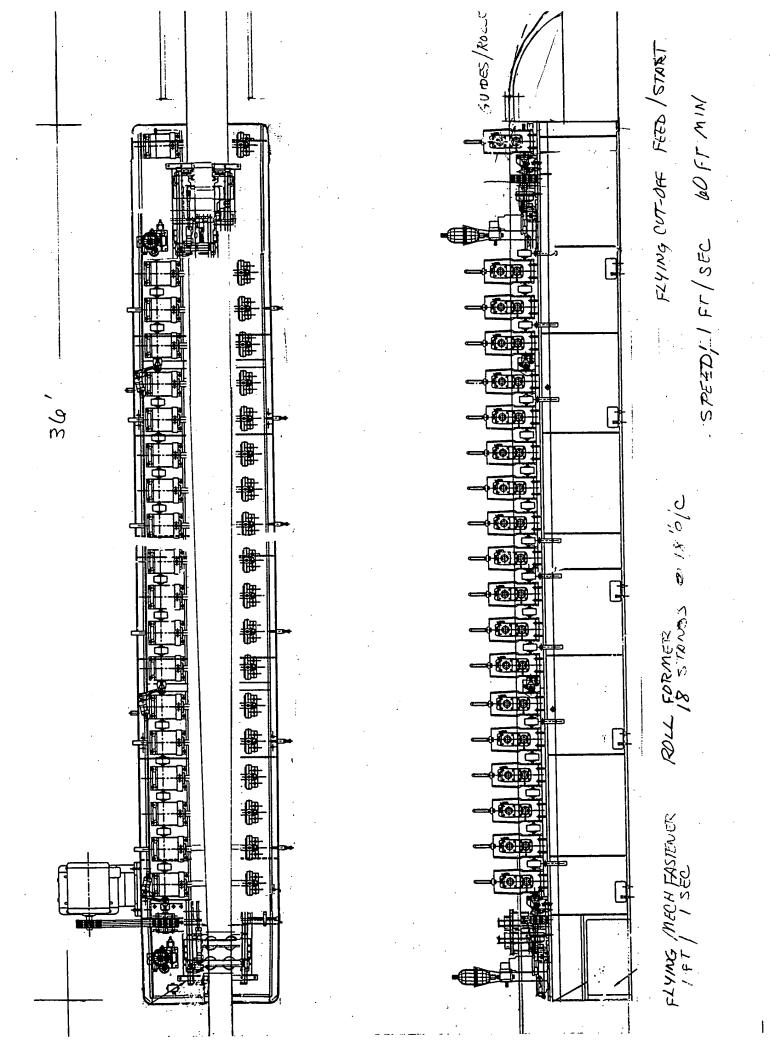
THIS QUOTATION IS FOR IMMEDIATE ACCEPTANCE AND SUBJECT TO CHANGE WITHOUT NOTICE. CLERICAL ERRORS ARE SUBJECT TO CORRECTION. DELIVERIES ARE CONTINGENT UPON PRIOR SALE AND DELAYS OCCASIONED BY STRIKES, FIRE, ACCIDENTS OR OTHER CAUSES BEYOND OUR CONTROL. WE WILL NOT BE RESPONSIBLE IF GOODS ORDERED PROVE TO BE AN INFRINGEMENT AGAINST PATENT RIGHTS. SHIPMENT SUBJECT TO BUYERS RISK.

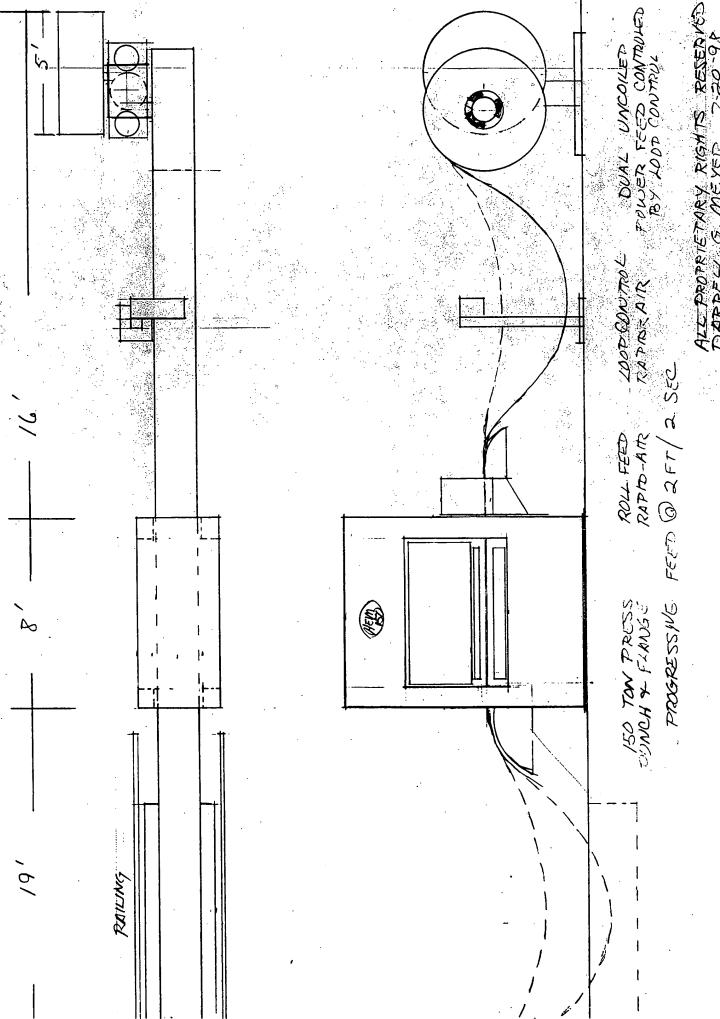
National Machinery Exchange, Inc.

Exhibit 38



/ IMPLIANT STACKER - GRAVITY S-72NEVARTIC STOPS COMVEYOR BELT / HYTROL TA S LIVE ROLLER COULCYRE HYTROL 138 SP





Oxhibit 39







THE LATEST IN QUALITY USED FABRICATING & CHIP MAKING MACHINERY . ALL MAJOR BRANDS BUY . SELL . TRADE

CRAFTSHAN DOOR

7/29/98

ATTN: DARRELL HEYER

We are pleased to offer the following for your consideration:

ONE (1) USED

17 Stand ARDCOR Model S10-2-1/2-33 Roll Former

SMET

SERIAL NUMBER: 90-052

AGE: 1990

SPECIFICATIONS:

17 Stand on 18 Stand Base Hand of Line: Right to Left Capacity: .048" or 18 Ga.

Line Speed: 60 FPM (Via Pulley Drives)

Spindle Diameter: 2-1/2"

Roll Space: 33"

Horizontal Distance: 10"

Vertical Adjustment: 4" - 5-1/4"

Base to Centerline of Lower Spindle: 5-3/4"

Passline: 40"

Spindle Gear Ratio: 1:1 (Equal Geared)

Drive Reduction Ratio: 12:1 Key Way Size: 3/8" x 3/16"

EQUIPPED WITH: Individual Gear Box Drives

Air Clutch

Micrometer Adjustment on Rolls

(3) Side Pass Guides
Push Button Controls
Electrical Control Panel

Coolant Pump

Motor Data: 40 HP, 220/440/3/60 - 1200 RPM Overall Size: 17'6'' L x 6' W x 52'' High

Weight: 18,000 Lbs. Total

Condition: VERY GOOD

**PHOTO & CATALOGUE CUTS AVAILABLE

PRICE: \$84,500.00

THANK you RICK KRUGER







THE LATEST IN QUALITY USED FABRICATING & CHIP MAKING MACHINERY . ALL MAJOR BRANDS BUY . SELL . TRADE

CRAFTSMAN DOOR ATT & DARREZL MEYER

7/29/48

OFFER TO SELL We offer the following subject to the supplemental terms and conditions

17 Stand Yoder Roll Former

Serial No.: 7103-677

Year: 1977

Unequal Geared

36" Roll Space - T - 560 TT &D

4" - 8" Vertical Adjustment

15" Horizontal Center Dist.

2 1/2" Spindle Diameter

Speed: 300 FPM

40 HP Drive, 220/440V, 1740 RPM

Air clutch/Brake Coolant System 10 Spare Shafts

Base dimension: 31" High x 64" Wide x 23' Long

THANK-you RICK KRUGOR







THE LATEST IN QUALITY USED FABRICATING & CHIP MAKING MACHINERY . ALL MAJOR BRANDS BUY . SELL . TRADE

CRAFTSMAN DOOR ATTN: DARRELL MEYER 7/29/98

Gentlemen: We are pleased to offer, subject to prior sale and conditions on back:

** ONE(1) PRE OWNED PEARSON MODEL 16-2.5-40 ROLL FORMING LINE **

Serial Number:

R223

Date of Manufacture:

1967

NUMBER OF STANDS:

18

ARBOR (SHAFT) DIAMETER:

2 1/2"

ROLL SPACE:

30"

HORIZONTAL SPACE - C TO C BETWEEN STANDS:

14"

VERTICAL CENTERS:

5" - 7"

SPEED:

25/36/47/57/67/82/86/123 FPM

Equipped with:

EQUAL GEARING

REMOTE OPERATOR CONTROLS PENDANT

BASE DRILL AND TAPPED FOR ROLL SPACE ADJUSTMENT ON 8" INCREMENTS EGAN 20,000# MOTORIZED UNCOILER - HYDRAULIC EXPANSION - 72" OD X 40" YODER P60 CUT OFF PRESS - 3" STROKE - 32" X 16" BED AREA - AIR CLUTCH

NOTE: MACHINE IN PLANT UNDER POWER UNTIL 31 MAY 1998

MOTOR:

40 HP., 3/60/220-440

Dimensions of Machine:

48'(LR) X 60"(FB) X 72"(H)

Weight:

16000#

Price - FOB Open Top Truck - , PLANT LOCATION

\$112,500.00

THANK you

RICK Klaugor

OK ON THE DUM

Sterling Machinery Exchange WEB:WWW.sterlingmachineryexch.com 9310 GARVEY AVE SOUTH EL MONTE, CA 91733

RICK

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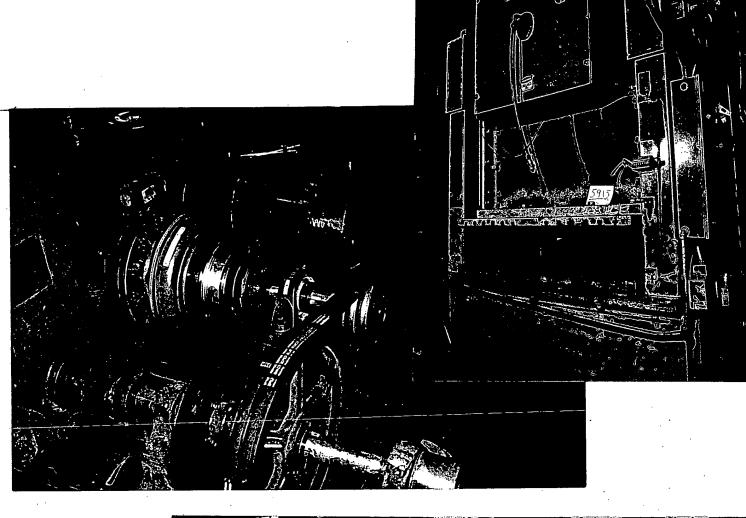
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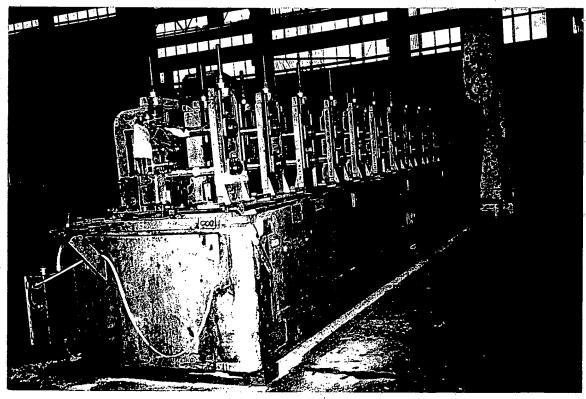
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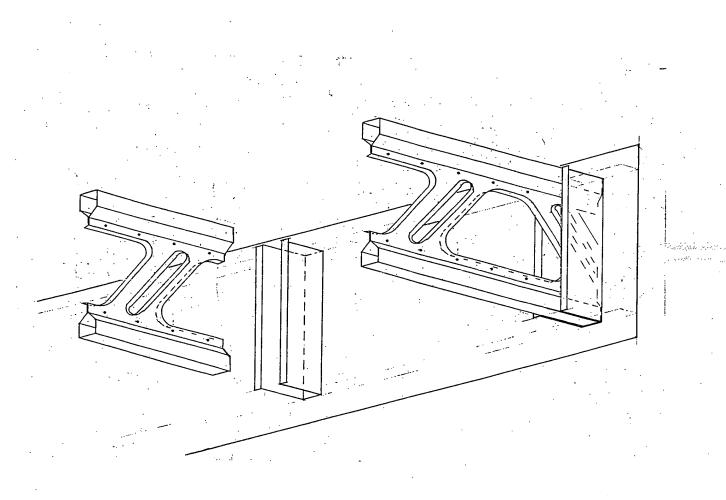


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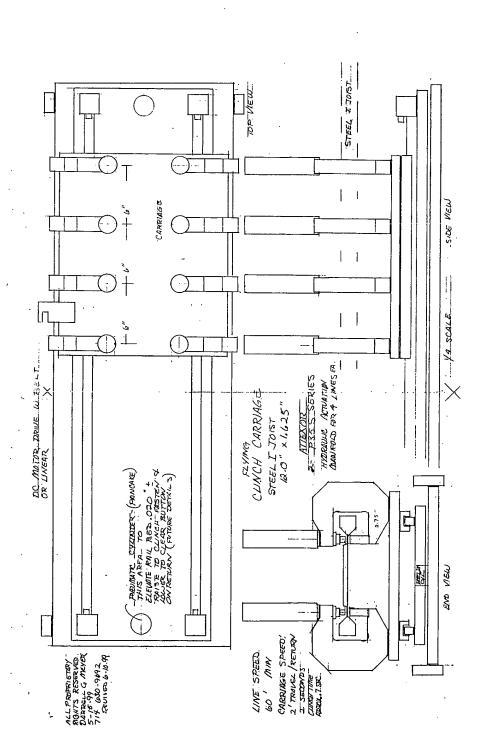


exhibit 41

STRUCTURAL EVALUATION OF STEELWORKS' SteellJoistTM

Prepared for

USS/POSCO 900 Loveridge Road Pittsburg, CA 94565

and

SteelWorks , 3822 E. La Palma Avenue Anaheim, CA 92807

bу

NAHB Research Center, Inc. 400 Prince George's Boulevard Upper Marlboro, MD 20774-8731

June 1999

NA-B RESEARCH CENTER

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America's Housing Technology and Information Resource

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June 1999

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The principal author and investigator of this report is Nader R. Elhajj, P.E. Technical review was provided by Jay Crandell, P.E. Lab support was provided by Christian Jacobs and administrative support was provided Lynda Marchman.

Table of Contents

Acknowledgements	iii
1.0 Introduction	
2.0 Experimental Approach	
3.0 Test Results	7
4.0 Analysis of Test Data	11
5.0. Summary Conclusion and Recommendations	12
6.0 References	14
Appendix A - Test Results	
Appendix B - Safety Factor Calculation	
Appendix C - Test Photographs	
Appendix D - Test Plots	
Appendix E - Metric Conversion	

1.0 Introduction

Over the past several years, the materials used to construct the frame of a home have been subject to various forces that have contributed to upward pressures on home prices. Unpredictable fluctuations in the price of framing lumber, as well as concerns with its quality, have caused builders and contractors to seek alternative building products.

Cold-formed steel (CFS) joists have been used where large spans are called for and where engineered wood joists are too costly to use. However, one of the major barriers to the use of CFS floor joists is the impact it has on placement of large waste drains and ductwork installed in the floor system. Current requirements limit maximum hole (opening) sizes in CFS joists to about 2.5-inches (6.35 cm) in diameter. This limitation can accommodate short plumbing runs and electrical wiring, but restricts the use of larger and longer septic drains and ductwork.

The SteelIJoistTM provides the builder with a truss shaped joist with lengths up to 40 feet that can easily accommodate plumbing and waste lines as well as HVAC installation. The SteelIJoistTM is fabricated by a continuous roll forming process with punched openings, formed flanges, and mechanically fastened chord sections. The top and bottom chord sections of a SteelIJoistTM have pentagonal shapes that provide flat sides for attachment to end caps, hangers and brackets. Each SteelIJoistTM has trapezoidal shaped folded web openings at 24 inches on center, along the entire length of the joist that can accommodate up to 6-inch diameter passage for utilities. A web foldout further stiffens the web between the trapezoidal openings. The joist system comes with a predesigned and precut end cap that fits on either end of the joist. The end cap is used to attach the SteelIJoistTM to the rim track. The SteelIJoistTM comes in one size that is 12'-inches deep with two thicknesses, 18 and 20 gauge, as shown in Figure 1.

Some of the practical benefits of this innovation in the design of CFS floor joists are as follows:

- job site flexibility (i.e. constructability);
- allowance for larger HVAC ducts, plumbing, and electrical systems in the floor cavity;
- elimination of shrinkage problems occasionally experienced with wood frame floors;
- capability of long spans;
- light weight (approximately 2.8 lb/ft);
- may be cut at any dimension using end caps;
- factory end caps (two types) that are easy to attach; and
- factory rim tracks (bands) with end caps attached available.

The objective of this test program is to determine the structural performance of 18 gauge and 20 gauge, 12-inches deep SteelIJoistTM. Joist serviceability issues (such as vibration and noise) are not addressed in this report.

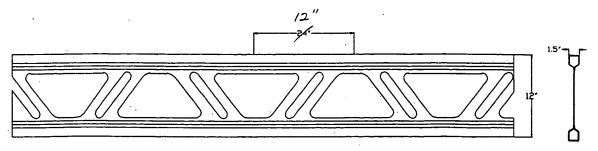


Figure 1 - SteellJoist™ Detail

2.0 Experimental Approach

Test Plan and Specimens

A total of 39 SteelIJoist™ joist assemblies and components were tested in a variety of configurations as shown in Table 1. All steel materials had a minimum specified tensile strength of 50 ksi that was verified by tensile tests in accordance with ASTM A370 [1]. Tensile tests were performed on a sample of three joists for each joist thickness. Base steel thicknesses were measured in accordance with ASTM A90 [2]. Mechanical properties were based on coupons cut longitudinally from the center of the specimen's web.

Table 1
SteelLloist™ Test Plan

SteelLJoist™ Web Depth (in)	Thickness (Gauge)	Yield Strength (ksi)	Span Length (ft-in)	Test No.	Planned Loading and/or Failure Mode
12	- 20	50	2'-0"	1,2	Shear
12	, 20	50	10'-0"	3,4	Combined Shear & Bending
12	, 20	50	18'-0"	5,6	Bending
12	18	50	2'-0"	7,8	Shear
12	18	50	10'-0"	9,10	Combined Shear & Bending
12	18	50	18'-0"	11,12	Bending
12	20	50	2'-0"	13,14	Shear with end caps
12	18	50	2'-0"	15,16	Shear with end caps
12	20	50	6'-0"	17	Mid-span loading
12	20	50	6'-0"	18	Mid-span loading w/Drilled clinches
12	20	50	6'-0"	19,20	Mid-span loading w/Cut webs
12	18	50	6'-0"	21	Mid-span loading
12	18	50	6'-0''	22	Mid-span loading w/Drilled clinches
12	18	50	6'-0"	23,24	Mid-span loading w/Cut webs
12	18	50	8'-0"	25	8'-0" Rim Joist - Two point loading
12	18	50	6'-0"	26,27	6'-0" Rim Joist - Two point loading
End Cap	18	50	1'-0"	28,29,30	Compression load - Unstiffened end cap
End Cap	18	50	1'-0"	31,32,33	Compression load - Stiffened end cap
Coupon	20	50	0'-8"	34,35,36	Mechanical properties
Coupon	18	50	0'-8"	37,38,39	Mechanical properties
	Total No. of	tests		39	

Test Procedure

The specimens were tested in the NAHB Research Center's Universal Testing Machine (UTM) using the test method in ASTM D198-97 [3]. The ASTM standard requires specimens to be mounted in a testing apparatus capable of applying measurable loads at a constant load rate.

The cross-head of the UTM was fitted with an apparatus capable of applying the total load at one point or two points equidistant from the reactions. The locations of the two point loads and end reactions divide the specimen (bending test) into three equal sections. The load was applied by the UTM and transmitted to the load plates by a cross beam. The following information was recorded and reported for each test:

- Span length (see Table 1),
- · Load, support mechanics, and any lateral supports used,
- Rate of load application,
- Actual physical and mechanical properties, including thickness, yield strength, ultimate strength (coupon tests), and a statistical measure of variability of these values (see Tables A1, A2, and A3 of Appendix A),
- Description of observed failure mode, and,
- Ultimate loads and deflections and a statistical measure of variability of these values (see Tables A4 and A5 of Appendix A).

When thin steel bending members with web openings are subjected to loads, three failure modes may occur: (a) bending, (b) shear, (c) web crippling. Since end caps are used for each joist, web crippling failure modes has not been investigated in this report. Therefore, joists were tested to induce shear failure, bending failure, and combined shear and bending interaction failure.

Shear Test

The purpose of this test was to investigate the behavior of a SteelIJoist[™] when subjected to a constant shear force. Two different configurations were used for shear tests. The first set of tests was conducted without end caps installed at the ends of the each specimen. End caps were installed at the end of each specimen for the second set of tests to preclude web-crippling failure. Short span members were used to minimize the influence of bending. Each test specimen utilized a single joist, simply supported, with a 24-inch long span. Rollers and bearing plates were used at each end. The beam was restrained to prevent rotation. In addition, lateral supports braced the central portion of the joist to prevent lateral movements at mid span. A concentrated load was applied near the joist support, as shown in Figure 2. A deflection gage was placed under the joist to measure the vertical deflection of the test specimen at mid-span.

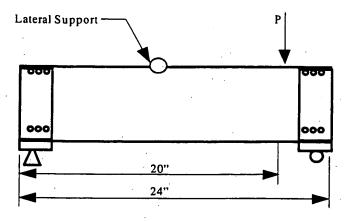


Figure 2 - Shear Test Setup (with end caps)

Bending Test

The purpose of this test was to investigate pure bending capacity of a SteelIJoistTM stabilized against lateral-torsional buckling. To stabilize the specimen against lateral-torsional buckling, each test specimen consisted of two SteelIJoistTM sections inter-connected by 23/32-inch thick oriented-strand-board (OSB) and 5/8- inch thick gypsum board strips. The 6-inch x 16-inch x 1/2-inch OSB strips were spaced at 24-inches on center and fastened to top flanges with #10 self-drilling, tapping screws (two screws per flange). The 5/8-inch gypsum board strips were also spaced at 24-inches on center and fastened to the bottom flanges with #10 self-drilling, tapping screws (two screws per flange). The test set up is shown in Figure 3. End caps were used at the end of the assembly to prevent the joists from moving laterally and rotating. Rollers and bearing plates were used at each end of the assembly. Two concentrated loads were applied at third point locations of each specimen. This loading arrangement provided a pure moment region in the central portion of the beam while the two end sections experienced a linearly increasing bending moment with increasing distance from the ends. A deflection gage was placed under the assembly at mid-span to measure the vertical deflection of the test specimen.

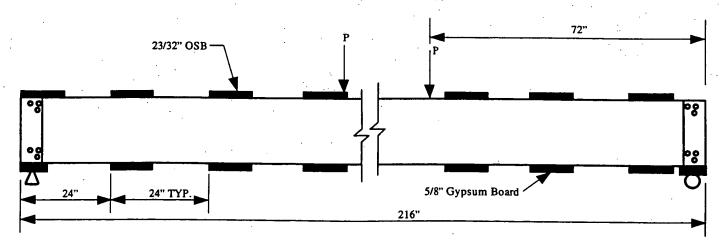


Figure 3 - Bending Tests Setup

Combined Shear and Bending (Interaction) Test

The purpose of this test is to investigate the behavior of a single SteelIJoist™ subjected to a combined shear force and bending moment. Each test specimen was tested as a continuous two-span beam subjected to two point loads. The continuous joist length was 10-feet, with each span 60-inches long. Point loads were applied at a distance of 30-inches from each end. Rollers and bearing plates were used at each end and a bearing plate was used at mid-span. End caps were used at the both ends to prevent the beam from moving laterally or rotating. In addition, lateral supports were attached to the central portion of the beam to prevent lateral-torsional buckling of the test specimens. Deflection gages were placed under each point load to measure the vertical deflection of the test specimen. The combined shear and bending test configuration is shown in Figure 4.

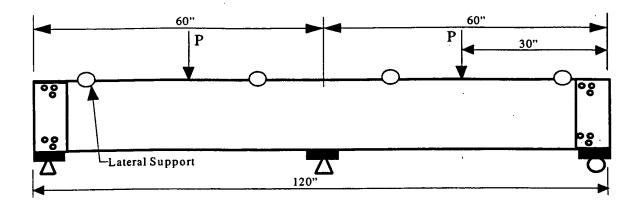


Figure 4 - Combined Bending and Shear Test Setup

Mid-Span Loading with Cut Webs or Drilled Clinches

The top and bottom chords of each SteellJoistTM are typically clinched at 3-inch on center. A six-foot joist specimen was tested with every other clinch drilled out to investigate the impact of increasing the spacing between clinches. Tests were also conducted to investigate the impact of removing one of the vertical folded webs along the beam except at the ends.

Tests were conducted utilizing single simply supported joists. Rollers and bearing plates were used at each end. End caps were used at the ends to prevent the joist from moving laterally or rotating. In addition, braces were attached to the central portion of the joist. The test configuration is shown in Figure 5.

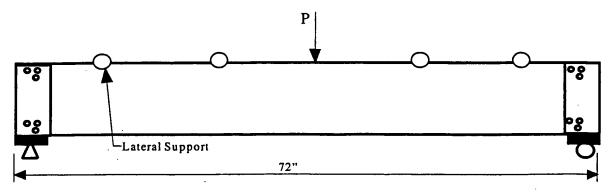


Figure 5 - Mid-span Loading for Drilled Clinches and Cut Webs Test Setup

Rim Joist Test

Two rim joist configurations were tested to determine their capacity in resisting gravity loads. The purpose of these tests is to investigate the potential use of the rim joists as headers.

One 8-foot and two 6-foot simply supported rim joist assemblies were tested. Rollers and bearing plates were used at each end. Partial SteelIJoistTM were fastened to the rim joist at 24-inches on center as shown in Figure 6. The rim joist assembly was stabilized against rotation and lateral buckling by using lateral supports. Point loads were applied at a distance of 1/3 span from each end.

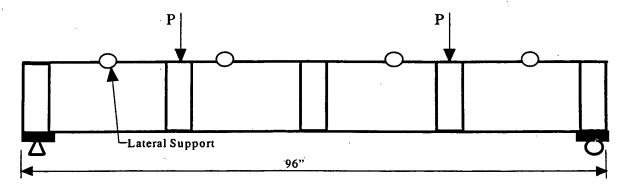


Figure 6 - Rim Joist Test Setup

End Cap Test

All end caps used in the tests were 43 mil (18 gauge) thick. Two end cap configurations were tested to establish their compressive strength. The two configurations are described below:

• Standard end cap consisting of a U-shaped section with return lips bent towards the outside of the U-shape as shown in Figure 7.

• Stiffened end cap with intermediate stiffeners along the flanges of the U-shaped section as shown in Figure 8.

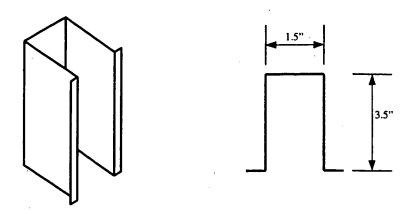


Figure 7 – Standard End Cap

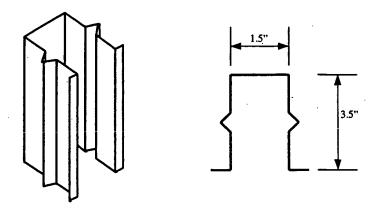


Figure 8 - Stiffened End Cap

3.0 Test Results

Tensile Coupon Tests

The mechanical properties of the steel used for the SteelIJoistTM specimens were established by standard tensile coupon tests as described previously. Table A1 (Appendix A) lists the tensile test data for yield strength (F_y) , ultimate tensile strength (F_u) , uncoated steel thickness (t) and percent elongation in 2-inch (5.1 cm) gage length. Mean property values shown in Table A2 of Appendix A were used for analytical purposes.

Shear Tests

Four SteelIJoistTM were tested for shear strength. The results are tabulated in Table A4 of Appendix A. Table 2 shows the average shear capacity at peak loads per web, V_t .

Table 2
Shear Test Results

SteelIJoist™ Size ¹	Span Length (in.)	V _t (lb.)				
12 x 33	24	1,402				
12 x 43	24	2,371				
12 x 33 w/end caps	24	3,246				
12 x 43 w/end caps	24	4,556				

Refer to Table 1 for actual joist dimensions.

Bending Tests

A total of four SteelIJoistTM specimens were tested for bending strength. The results are tabulated in Table A4 of Appendix A. Joist mid-span deflections were also recorded and tabulated in Table A5 of Appendix A. The average ultimate capacity, per joist, at peak load, $P_{u(test)}$, for each joist type is recorded in Table 3. Table 3 also lists the average ultimate moment capacity, M_t , for each test specimen computed on the basis of the average ultimate peak load, $P_{u(test)}$.

Table 3
Bending Test Results

SteelLJoist™ Size ¹	Span Length (in.)	P _{u(test)} (lb.)	Deflection @ P _{u(test)} ² (in.)	M _t (in-lb)
12 x 33	216	2,100	1.44	75,600
12 x 43	216	2,894	1.76	104,184

Refer to Table 1 for actual joist dimensions.

Combined Shear and Bending Tests

A total of four SteelIJoistTM specimens were tested and failed in combined shear and bending. The results are tabulated in Table A4 of Appendix A. Table 4 shows the average ultimate capacity at peak load, $P_{u(test)}$, the ultimate shear load, V_t , computed as $(0.69P_{u(test)}/2)$, and the ultimate bending moment, M_t , computed on the basis of V_t .

Table 4
Combined Shear and Bending Test Results

SteelLJoist™ Size ¹	Span Length (in.)	P _{u(test)} (lb.)	V _t (lb.)	M _t (in-lb)
12 x 33	120	4,124	1,423	23,136
12 x 43	120	5,604	1,933	31,438

¹Refer to Table 1 for actual joist dimensions.

²Deflection measurements were taken at mid-span.

Mid-Span Loading with Cut Webs or Drilled Clinches Tests

A total of one 6-foot, 18 gauge and one 6-foot, 20 gauge SteelIJoistTM were tested as simply supported spans subjected to a point load at mid-span to establish a base line capacity. Another 6-foot, 18 gauge and 6-foot, 20 gauge SteelIJoistTM specimens were tested with every other clinches drilled out. Two 6-foot, 20 gauge and two 6-foot, 18 gauge SteelIJoistTM specimens were also tested with the webs between the trapezoidal openings cut out. The webs at the ends of the joists remained uncut. The results are tabulated in Table A4 of Appendix A. Table 5 shows the average ultimate capacity at peak load, $P_{u(test)}$, and the ultimate bending moment, M_t , computed on the basis of $P_{u(test)}$.

Table 5
SteelIJoist™ with Drilled Clinches and Web Cut Outs Test Results

SteelLJoist™ Size¹	Span Length (in.)	Joist Condition	P _{u(test)} (lb.)	Deflection @ Pu(test) 2 (in.)	M _t (in-lb)
12 x 33	72	Master Joist	2,162	0.350	38,916
12 x 43	72	Master Joist	3,468	0.340	62,424
12 x 33	72	Drilled Clinches	2,052	0.310	36,936
12 x 43	72	Drilled Clinches	3,277	0.380	58,986
12 x 33	. 72	Webs Cut Out	2,065	0.345	37,170
12 x 33	72	Webs Cut Out	3,178	0.378	57,204

¹Refer to Table 1 for actual joist dimensions.

Rim Joist Tests

A total of three SteelIJoistTM rim joist specimens were tested for bending strength. The results are tabulated in Table A4 of Appendix A. Joist mid-span deflections were recorded and tabulated in Table A5 of Appendix A. The average ultimate capacity at peak load, $P_{u(test)}$, for each rim track is recorded in Table 6. Table 6 also lists the average ultimate moment capacity, M_t , for each test specimen computed on the basis of the average ultimate peak load, $P_{u(test)}$.

Table 6
Rim Track Test Results

Rim Joist Size	Span Length (in.)	P _{u(test)} (lb.)	Deflection @ Pu(test) (in.)	M _t (in-lb)
12 x 43	96	2,333	0.440	37,328
12 x 43	72	4,426	0.355	53,112

¹Deflection measurements were taken at mid-span.

End Cap Tests

A total of six SteelIJoistTM end caps were tested for compressive strength. The results are tabulated in Table A4 of Appendix A. The average ultimate capacity at peak load, $P_{u(test)}$, for each end cap is recorded in Table 7.

²Deflection measurements were taken at mid-span.

Table 7
End Cap Compression Test Results

Lite Cup Compression Test Results							
End Cap Thickness (mil)	End Cap Configuration	End Cap Height (in.)	P _{u(test)} (lb.)				
43	Unstiffened	12	11,323				
43	Stiffened	12	17,789				

Failure Modes

Shear

The maximum shear stress occurs at mid-depth of the web. Where web material is removed as for a web opening, a stress concentration is created at the corners of the opening that typically creates premature shear failure of the SteelIJoistTM. This failure mode, however, was not observed in the shear tests. In all specimens tested for shear, the failure mode was not pure shear failure. Failure occurred mainly due to web buckling, flange curling, web rotation, and/or stiffener buckling. This is a clear indication that SteelIJoistTM joists will not typically fail in shear.

Bending

For bending test specimens, the failure pattern is defined by either local buckling or mixed local and lateral-torsional buckling. The lateral-torsional buckling mode would typically result in premature web failure of test specimens. The test specimens did not show signs of lateral-torsional buckling. All test specimens failed in local buckling and yielding. The OSB and gypsum board strips provided adequate lateral strength to prevent the lateral-torsional mode of buckling. No deformation of the web openings was observed at failure of any of the specimens. Failed specimens were not severely deformed.

Combined Bending and Shear

For test specimens that failed by the combined shear and bending behavior, the failure pattern occurred as a bending type failure at mid-span and a diagonal shear failure between the load points. These two failure modes occurred simultaneously as the ultimate load was achieved. Folded edges at web openings or web stiffeners did not show any deformation at failure loads.

Mid-Span Loading with Cut Webs or Drilled Clinches

The failure pattern for these specimens was similar to the joists tested and failed in bending. Beam specimen with drilled clinches showed slight separation between the clinched sheets of the steel that are located within a close proximity to the loading plates. Deformation or failure of the clinches was not observed.

Beams with cut webs also exhibited a similar failure pattern to those beams tested for bending loads. Failure occurred by buckling in the webs within a close proximity to the loading plates.

Rim Joists

The 8-foot rim-joist specimen failed prematurely due to warping and lateral torsional buckling. The ends were

End Caps

)

 \mathbf{C}

All end-caps failed in column buckling at approximately mid-height.

4.0 Analysis of Test Data

The Steel Lioist™ performed extremely well in all tests. The bending, shear, and combined shear and bending strengths are well above those of a typical C-shaped 12-inch joist. Mid-span deflections were also within the recommended deflection limit (L/360 or L/480) that is usually used in designing residential and light commercial buildings.

Shear tests showed that a SteelUoist™ would perform better with end caps fastened to the ends of the joists. End caps are also necessary to eliminate potential failures due to web crippling.

Reducing the Number of Clinches

Tests with every other clinch drilled out resulted in a Steel IJoist™ ultimate capacity that is within 5 percent of that of a standard Steel IJoist™. Therefore, increasing the spacing between clinches will have negligible impact on the overall performance of the Steel IJoist™.

Cutting the Webs between Openings

Tests with webs between openings cut out (except for the end webs) resulted in a SteelIJoistTM ultimate capacity that is within 5 percent of that of a SteelIJoistTM without web cut outs. Therefore, cutting the webs along the length of a SteelIJoistTM will have negligible impact on the overall performance of the SteelIJoistTM.

Changing Number of Screws

Tests performed on SteelIJoist™ specimens with end caps fastened with 3-#10 screws instead of 5-#10 screws resulted in a capacity that is similar to those with 5-#10 screws. Therefore, end caps fastened to a SteelIJoist™ with 3-#10 screws should perform its intended function adequately.

SteelIJoist™ Allowable Loads

Table 8 summarizes the allowable tested values (using a factor of safety of 2.0 as calculated in Appendix B).

Table 8
Tested Allowable Loads

SteelIJoist TM Size ¹ (Web depth x thickness)	Failure Mode ²	Tested Ultimate Load ³ lb.	Allowable Tested Load ⁴ lb.		
12 x 33	Shear	1,402	701		
12 x 33	Shear w/end caps	3,246	1,623		
12 x 33	Bending	2,100	1,050		
12 x 33	Shear & Bending	4,124	2,062		
12 x 43	Shear	2,371	1,186		
12 x 43	Shear w/end caps	4,556	2,278		
12 x 43	Bending	2,894	1,447		
12 x 43	Shear & Bending	5,604	2,802		

¹Refer to Table 1 for actual joist dimensions.

Table 9 provides the SteelLioist[™] maximum allowable spans for residential floors. The spans are based on a maximum uniform live load of 30 and 40 psf and maximum floor dead load of 10 psf.

Table 9 Allowable Spans for SteelLJoist™ Floor Joists¹

SteelLJoist™ Depth	Steel ThicknessGa uge	30 psf Live Load SteelIJoist™ O.C. Spacing			40 psf Live Load SteelIJoist™ O.C. Spacing				
12	20	25'-1"	21'-9"	19'-11"	17'-9"	22'-5"	19'-5") 17'-9"	15'-11"
12	18	29'-6"	25'-6"	23'-4"	20'-10"	26'-4"	22'-9"	20'-10"	18'-8"

¹All steels shall have minimum yield strength of 50 ksi.

5.0 Summary, Conclusion and Recommendation

The objective of this investigation was to study the behavior of SteelIJoist™ floor joist members with trapezoidal web openings with folded edges subjected to shear, bending, and combined shear and bending. The trapezoidal web opening had folded edges that stiffened the web around the opening. A total of 39 tests were performed. Based on the findings of this study, the following conclusions and recommendations regarding the behavior and installation of SteelIJoist™ floor joists with relatively large, stiffened openings (i.e. folded edges) under gravity loads can be made:

• The presence of trapezoidal web openings with folded edges did not reduce the ultimate shear, bending, and combined shear and bending strengths. Actually, the folded edge web openings resulted in an increase in the strength of joist specimens investigated in this study.

³Values are based on an average of two tests (minimum) per configuration.

The allowable tested load is calculated as the tested "ultimate" load divided by a factor of safety of 2.0 (refer to Appendix B).

- The presence of trapezoidal web openings did not promulgate any failure. All observed failures took place at a distance from the openings. None of the web openings experienced any significant deformation under any of the loading conditions examined.
- Shear strength was not a controlling factor in the design of SteelIJoist™ joists with web openings as identified in this report. Pure shear failure did not occur in any of the tested specimens.
- SteelIJoist[™] joists with trapezoidal web openings (with folded edges) can be safely used in residential and light commercial construction to accommodate long septic drains, plumbing runs, routing of ductwork, and other trade installations.
- SteelUoist[™] joists provide clear unsupported spans that exceed those for typical C-shaped joists by approximately 25%. This would allow the end user to drop at least one gauge for a particular span. The SteelUoist[™] joist allows the end user to utilize lighter gauge steels that are not available in regular C-shaped joists. Using lighter gauge steels would result in lower material and labor costs (especially fastening time).
- The on center spacing between the clinches can be safely increased to 4 or 5-inches without any degradation in the strength of the joist.
- One web of each trapezoidal opening can be safely removed without any degradation in the strength of the joist (webs should not be removed at either end of the joist).
- The number of screws connecting the end caps to the SteelIJoist™ ends can be reduced to 3-#10 screws without degrading the strength of the joist. Further reduction in the number of screws per side should be investigated.
- The top and bottom chord flange widths of 1-1/2" could cause a problem for fastening sheathing and drywall to the joist. A minimum of 1-5/8" flanges should be specified. This would give the framers more flat surface to accommodate two sheets of sheathing and would eliminate potential concerns by end users. This change would also make the SteelIJoistTM flange width similar to that specified for typical C-shaped joists.
- A 10-inch deep Steel Joist™ is expected to behave as well as or better than the 12-inch deep joist tested in this report. This will result in tremendous savings in steel and provides an additional 2-inches of headroom.
- Web openings foldouts have sharp edges. This would cause significant concerns to subtrade installations. Sharp edges should be smoothed out.
- The end-cap connection to the joist requires an added effort that could impact the efficiency or cost-effectiveness of the SteelIJoist™. A better connection detail utilizing the rim track should be investigated.

6.0 References

- [1] ASTM A 370- 1997a, Standard Test Methods and Definitions for Mechanical Testing of Steel Products, American Society for Testing and Materials (ASTM), West Conshohocken, PA.
- [2] ASTM A 90/A90M-1995, Standard Test Method for Weight [Mass] of Coating on Iron and Steel Articles with Zinc or Zinc-Alloy Coatings, American Society for Testing and Materials (ASTM), West Conshohocken, PA.
- [3] ASTM D 198-1997, Standard Test Methods of Static Tests of Lumber in Structural Sizes. American Society for Testing and Materials (ASTM), West Conshohocken, PA.

APPENDIX A

TEST RESULTS

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Table A1

Physical and Mechanical Properties of Test Specimens

SteelIJoist TM Size (web depth x thickness)	Web Size (in)	Top Chord Width (in)	Bottom Chord Width (in)	Thickness (mil)	Yield Point ¹ (ksi)	Tensile Strength ¹ (ksi)	Uncoated Thickness ² (in.)	Elongation ³ (percent)
12x33	12	1.5	1.5	33	51,025	61,560	0.0345	15.1
12x33	12	1.5	1.5	33	52,340	61,395	0.0347	16.2
12x33	12	1.5	1.5	33	51,780	61,508	0.0348	15.9
12x43	12	1.5	1.5	43	52,220	61,468	0.0465	14.8
12x43	12	1.5	1.5	43	51,980	62,120	0.0468	16.1
12x43	12	1.5	1.5	43	51,800	61,030	0.0465	15.8

Table A2

Mean Physical and Mechanical Properties of Test Specimens^{1,2}

SteelLJoist TM Size (web depth x thickness)	Yield Point (ksi)	Tensile Strength (ksi)	Uncoated Thickness (in.)	Elongation (percent)
12 x 33	0.0347	51,715	61,488	15.7
12 x 43	0.0467	52,000	61,539	15.6

¹Values shown represent the mean of three tests per specimen.

Table A3

Standard Deviation and Coefficient of Variation of Physical and Mechanical Properties

C 177 1 1794 C'	Standard Deviation (σ)					
SteelIJoist™ Size (web depth x thickness)	Yield Strength (ksi)	Tensile Strength (ksi)	Uncoated Thickness (in.)			
12 x 33	660	84	0.568			
12 x 43	211	549	0.681			
SteellJoist™ Size	Coefficient Of Variation (COV) 1					
(web depth x thickness)	Yield Strength	Tensile Strength	Uncoated Thickness			
12 x 33	0.013	0.001	0.036			
12 x 43	0.004	0.009	0.044			

COV equals the standard deviation divided by the mean.

Tested per ASTM A 370 [14].

Tested per ASTM A 90 [15].

Tested per ASTM A 370 [14] for a 2-inch gauge length.

²Refer to Table A3 for standard deviation and coefficient of variation (COV).

Table A4 Tested Ultimate Capacity of SteelIJoist™

Test No.	SteelIJoist™ Size ¹	Joist Thickness (gauge)	Joist Span (ft-in.)	Test Mode	Ultimate Load ² (lb)	Mid-span Deflection ³ (in)
<u> </u>	10 22					216
1	12 x 33	20	2'-0"	Shear	1,371	0.165
2	12 x 33	20	2'-0"	Shear	1,432	0.137
3	12 x 33	20	10'-0"	Shear & Bending	3,936	0.435
4	12 x 33	20	10'-0"	Shear & Bending	4,312	0.400
5	12 x 33	20	18'-0"	Bending	4,114 ⁽⁴⁾	1.400
6	12 x 33	20	18'-0"	Bending	4,284 ⁽⁴⁾	1.480
7	12 x 43	18	2'-0"	Shear	2,305	0.180
8	12 x 43	18	2'-0"	Shear	. 2,436	0.230
9	12 x 43	18	10'-0''	Shear & Bending	5,812	0.430
10	12 x 43	18	10'-0"	Shear & Bending	5,396	0.375
,11	12 x 43	18	18'-0"	Bending	5,786 ⁽⁴⁾	1.760
12	12 x 43	18	18'-0"	Bending	5,787 ⁽⁴⁾	1.760
13	12 x 33	20	2'-0"	Shear with end caps	3,202	0.135
14	12 x 33	20	2'-0''	Shear with end caps	3,289	0.130
15	12 x 43	18	2'-0"	Shear with end caps	4,632	0.138
16	12 x 43	18	2'-0"	Shear with end caps	_ 4,479	0.115
17	12 x 33	20	6'-0"	Mid-span loading	2,162	0.350
18	12 x 33	20	6'-0''	Drilled clinches	2,052	0.310
19	12 x 33	20	6'-0"	Cut webs	2,025	0.290
20	12 x 33	20	6'-0"	Cut webs	2,105	0.400
21	12 x 43	18	6'-0"	Mid-span loading	3,468	0.340
22	12 x 43	18	6'-0"	Drilled clinches	3,277	0.380
23	12 x 43	18	6'-0''	Cut webs	- 3,139	0.335
24	12 x 43	18	6'-0"	Cut webs	3,216	0.420
. 25	12 x 43	18	8'-0"	Rim Joist	2,333	0.440
26	12 x 43	18	6'-0"	Rim Joist	4,513	0.390
27	12 x 43	18	6'-0"	Rim Joist	, 4,338	0.320
28	End cap	18	12"	Unstiffened end cap	11,034	-
29	End cap	18	12"	Unstiffened end cap	11,800	-
30	End cap	18	12"	Unstiffened end cap	11,135	•
31	End cap	18	12"	Stiffened end cap	16,150	-
32	End cap	18	12"	Stiffened end cap	18,034	•
33	End cap	18	12"	Stiffened end cap	19,183	-

Refer to Table 1 for actual joist dimensions.

The ultimate load is the total vertical load applied to the joist at peak load.

Mid-span deflections recorded at ultimate loads.

Ultimate load for two joists.

APPENDIX B
SAFETY FACTOR CALCULATION

SAFETY FACTOR CALCULATION

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The factor of safety used in estimating the tested allowable loads from the tested ultimate loads, in Table 11 is calculated in accordance with Section F of the AISI Design Specification [3] as follows:

The allowable axial capacity $R_a = R_n/\Omega$.

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Where: R_n = Average value of the test results.
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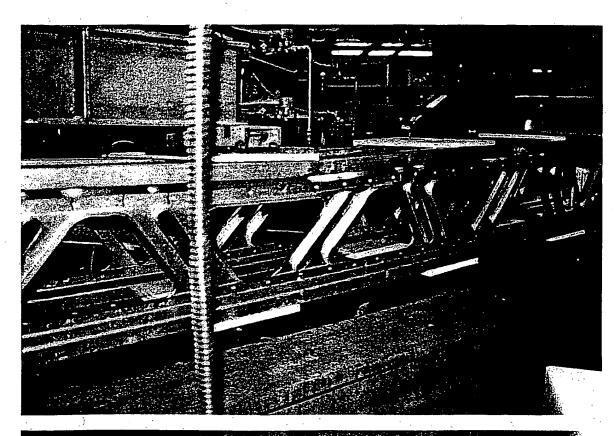
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\Omega = Factor of safety = 1.6/\phi
        = Resistance factor = 15(M_m F_m P_m)e^{-\beta_0 \sqrt{V^2_M + V^2_F + C_p V_p^2 + V^2_Q}}
        = Mean value of the material factor = 1.10
M_{m}
        = Mean value of the fabrication factor = 1.00
F_{m}
        = Mean value of the professional factor for the tested component = 1.0
P_{m}
        = Target reliability index = 2.5
\beta_0
        = Coefficient of variation of the material factor = 0.10
V_{M}
        = Coefficient of variation of the fabrication factor = 0.05
V_{F}
        = Correction factor = 5.7
C_{P}
        = Coefficient of variation of the test results = 4.65% (see note below)
V_{P}
        = 4.65\% (for V_p < 6.5\%, use 6.5%)
V_P
       = Degree of freedom = 1
m
        = Coefficient of variation of the load effect = 0.21
V_{Q}
        = 1.5(1.10x1.00x1.00)e^{-2.5\sqrt{0.10^2+0.05^2+5.7x0.065^2+0.21^2}} = 0.81
        = 0.81
```

 Ω = Factor of safety = 1.60/ ϕ = 1.60/0.81 = 1.975 (conservatively, use 2.0)

Note: The coefficient of variation (COV) of the test results is obtained by calculating the average COV of the individual COVs for each set of tests (minimum of two-test samples) and adding one standard deviation. The average COV is calculated to be 2.73 percent for all test groups. The standard deviation of all test group COVs is 1.92 percent. Therefore, the representative COV is 2.73 + 1.92 = 4.65. This represents an upper 64 percentile (plus one standard deviation) of the COV experience in the tests. It does not represent the "global" COV that may be experienced by multiple producers in various production runs. Considering this source variance in real production may tend to increase the safety factor estimate. The conservative bias relation to specific minimum strength versus actual strength is not considered in the safety factor determination. Considering this effect would tend to lower the safety factor estimate.

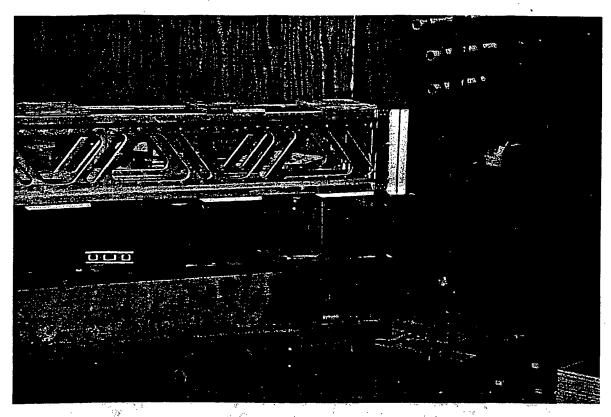
APPENDIX C

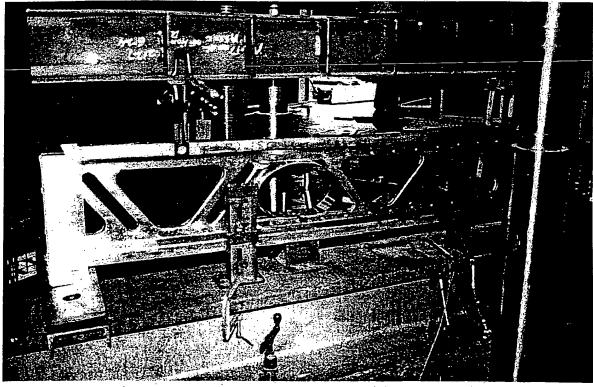
TEST PHOTOGRAPHS

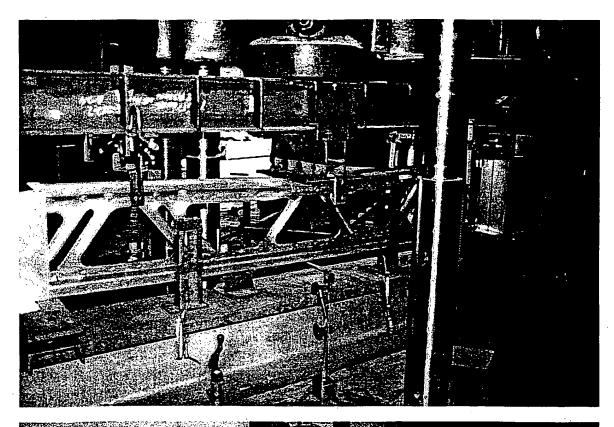


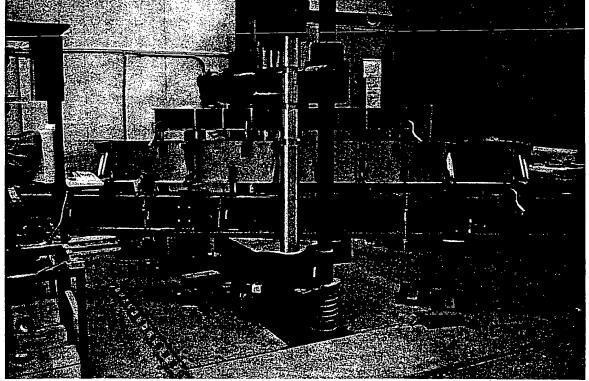


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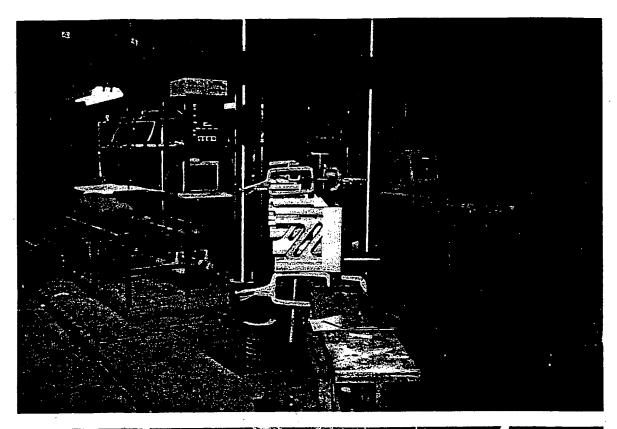


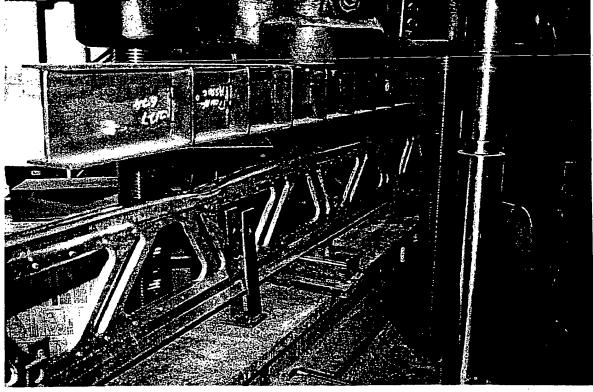


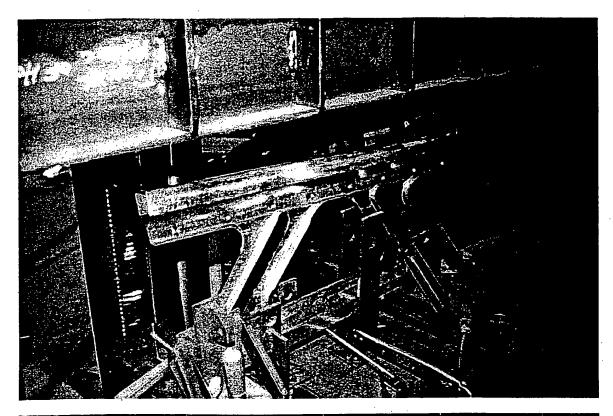


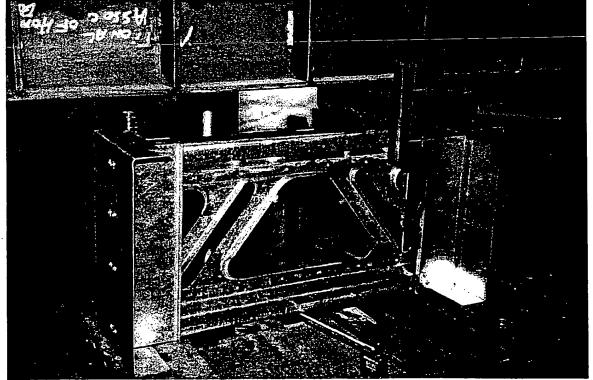
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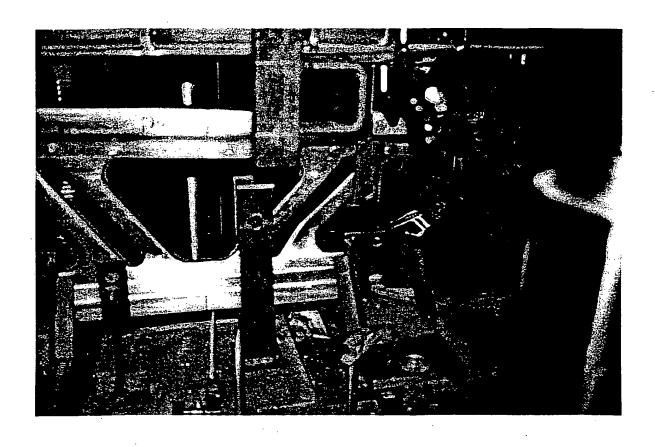








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APPENDIX D

TEST PLOTS

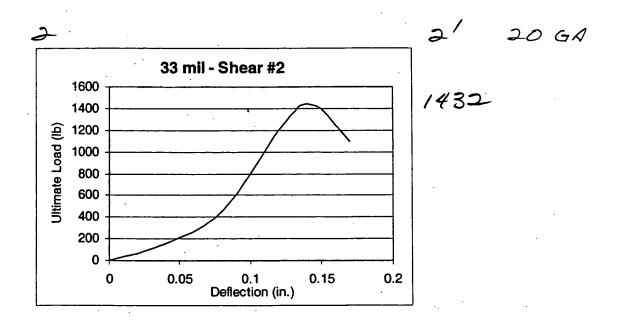
33 mil - Shear #1. 1600 1400 137/ Ultimate Load (lb) 1200 1000 800 600 400 200 0 0.05 0.1 Deflection (in.) 0 0.15 0.2

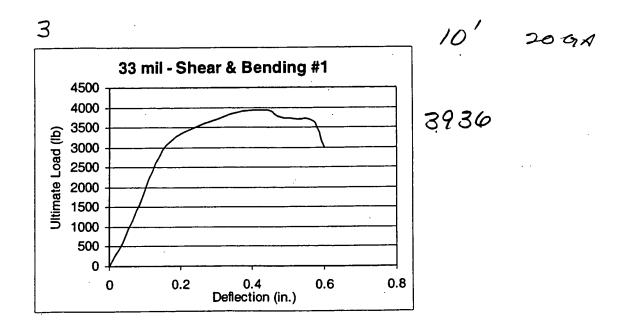
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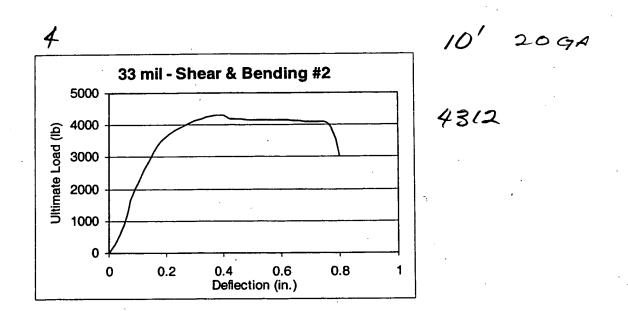
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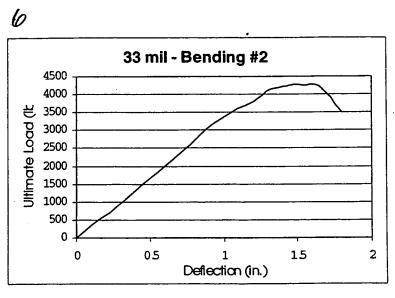
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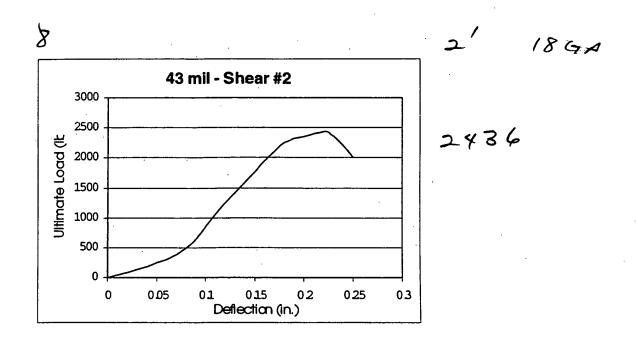


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0.25

0.05

1 0.15 (Deflection (in.)

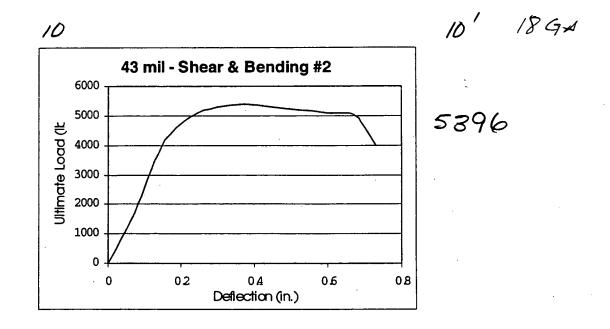


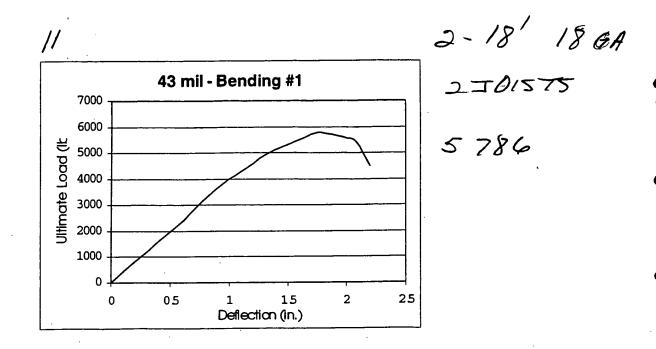
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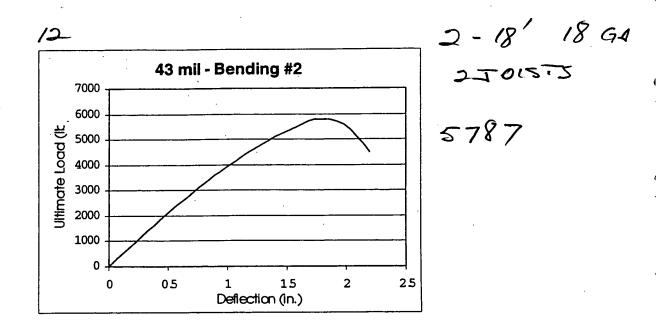
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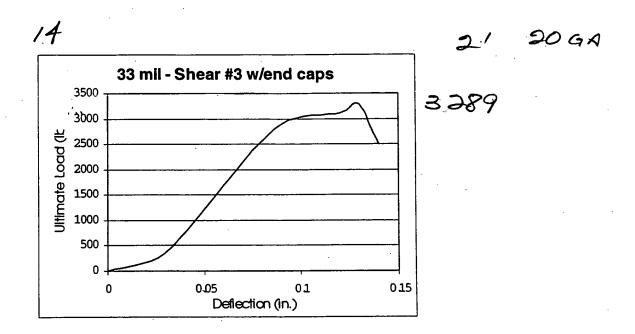


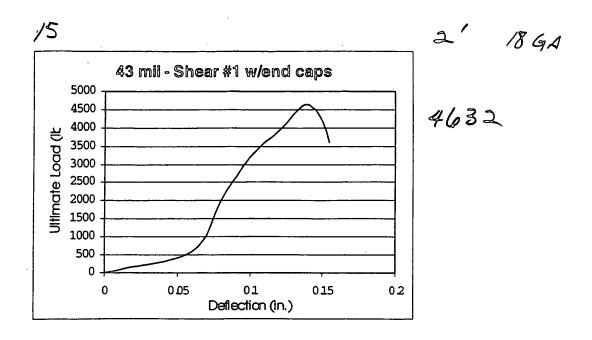
33 mil - Shear #2 w/end caps
3500
3000
2500
2500
1500
1000
500
0 0.05
Deflection (in.)

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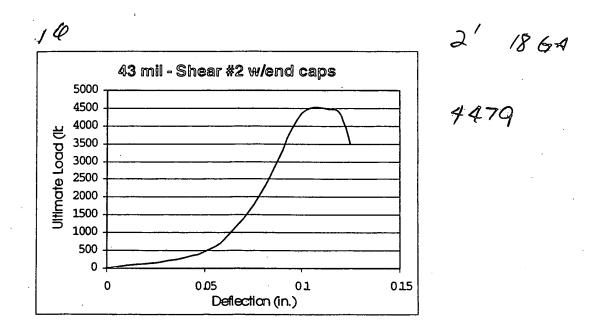
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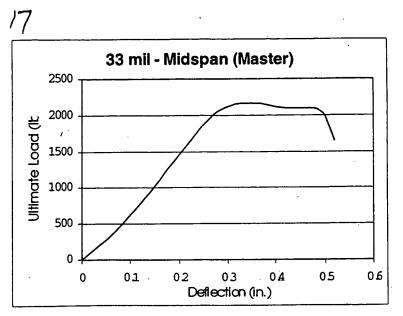
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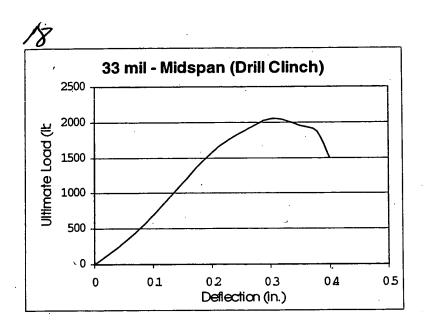
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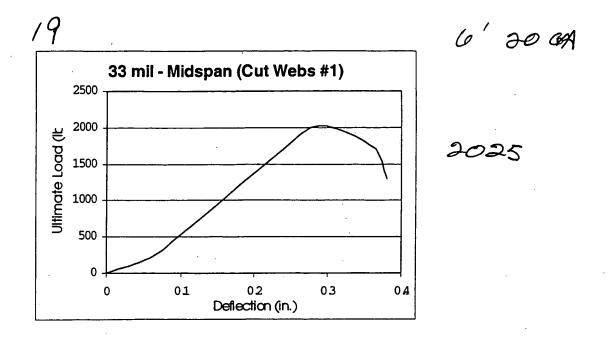
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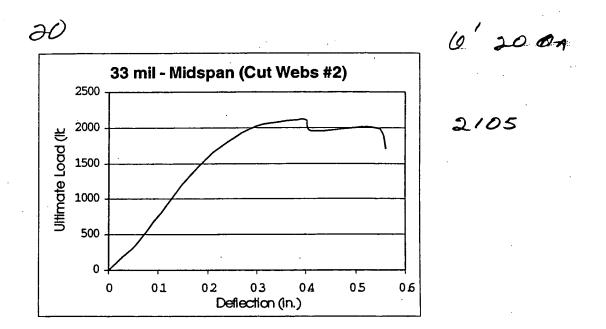
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6' 1801 21 43 mil - Midspan (Master) 4000 3500 3000 ppo 2500 2000 1500 1000 3468 500 0 03 04 05 **a**0 01 02 Deflection (in.)

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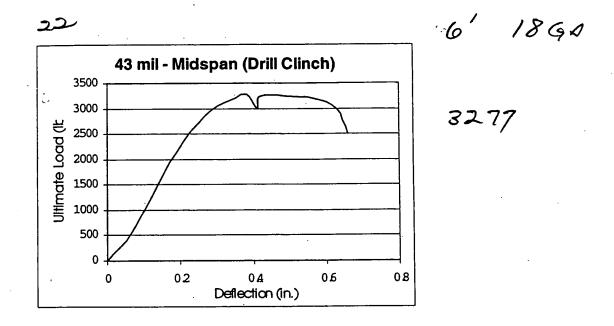
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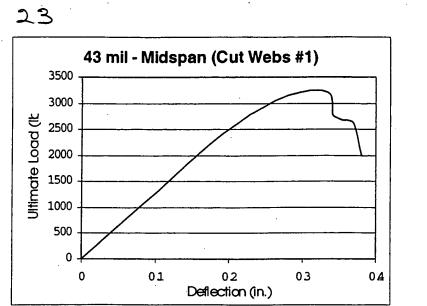
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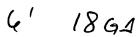
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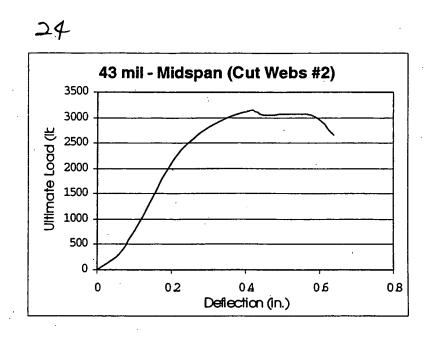
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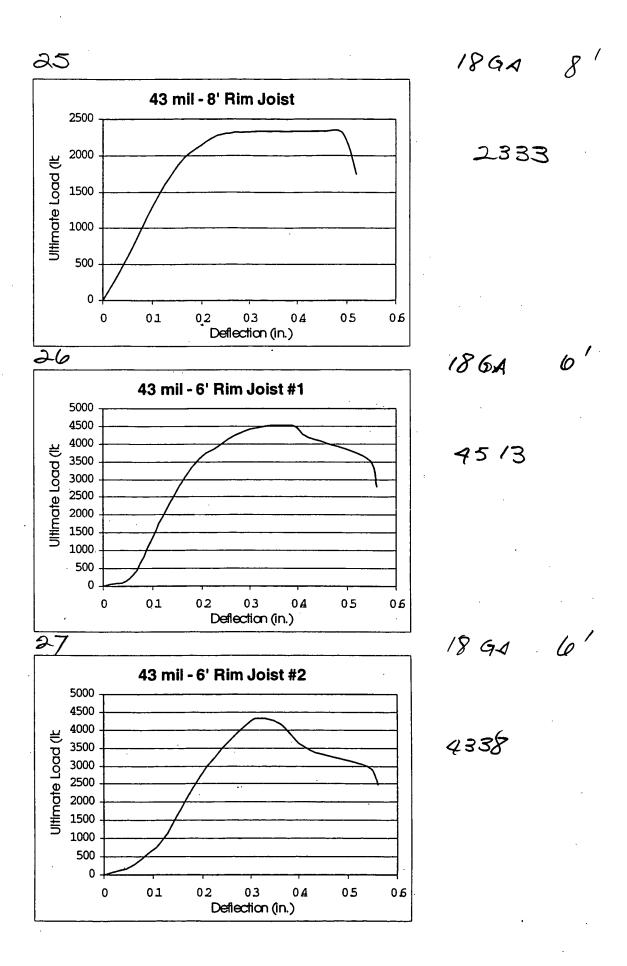


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6' 18 GA

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APPENDIX E
METRIC CONVERSION

METRIC CONVERSION FACTORS

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The following list provides the conversion relationship between U.S. customary units and the International System (SI) units. A complete guide to the SI system and its use can be found in ASTM E 380, Metric Practice.

To convert from	to	multiply by	To convert from	to	multiply By
Length			Mass (weight)		
	micrometer (μm)	25,400	pound (lb.) avoirdupois	kilogram (kg)	0.4535924
inch (in.)	millimeter (mm)	25.4	ton, 2000 lb.	kilogram (kg)	907.1848
nch (in.) nch (in.)	centimeter (cm)	2.54	grain	kilogram (kg)	0.0000648
nch (in.)	meter (m)	0.0254			
	meter (m)	0.3048	Mass (weight) per length)		•
foot (ft) yard (yd)	meter (m)	0.9144	, -	·	
mile (mi)	kilometer (km)	1.6	kip per linear foot (klf)	kilogram per	0.001488
	KHOIDEGI (KIII)			meter (kg/m)	
Area			pound per linear foot (plf)	kilogram per meter (kg/m)	1.488
		0.0929	Moment		
	quare centimeter (sq. cm)	0.432 0.00064516	Monient		
square inch (sq. in.) so		0.8391	1 foot-pound (ft-lb.)	Newton-meter	1.356
square yard (sq. yd) sc	quare meter (sq. m)		1 Toot-pound (it 10.)	(N-m)	
square mile (sq. mi) sc	quare kilometer (sq. km)	2.0			
Volume			Mass per volume (density))	
cubic inch (cu in.) ci	ubic centimeter (cu cm)	16.387064	pound per cubic foot (pcf)	kilogram per	16.01846
cubic inch (cu in.)	cubic meter (cu m)	0.00001639	•	cubic meter (kg	
cubic floot (cu ft)	cubic meter (cu m)	0.02831685	pound per cubic yard	kilogram per	0.5933
cubic yard (cu yd)	cubic meter (cu m)	0.7645549	(lb/cu_yd)	<u>cubic meter (kg</u>	/cu m)
gallon (gal) Can. liquid		4.546			
gallon (gal) Can. liquid		0.004546	Velocity		
gallon (gal) U.S. liquid		3.7854118			
gallon (gal) U.S. liquid	d cubic meter (cu m)	0.00378541	mile per hour (mph)	kilometer per h	our 1.60934
fluid ounce (fl oz)	milliliters (ml)	29.57353	·	(km/hr)	
fluid ounce (fl oz)	cubic meter (cu m)	0.00002957	mile per hour (mph)	kilometer per s (km/sec)	econd 0.44704
Force				(KIIIISCA.)	
			Temperature		
kip (1000 lb.) kii	logram (kg)	453.6	· · · · · · · · · · · · · · · · · ·	0.1: (00)	2011 6
kip (1000 lb.) No	ewton (N)	4,448.222		egree Celsius (°C)	
pound (lb.) kil	logram (kg)	0.4535924		egree Kelvin (°K)	
	ewton (N)	4.448222	degree Kelvin (°F) de	egree Celsius (°C)	$t_C = (t_K - 32)/1.8$
Pourie (101)					
Stress or pressure			* One U.S. gallon equals 0.8 ** A pascal equals 1000 New	327 Canadian gallor ton per square meter) :
Stress or pressure	meganascal (Mna)	6.894757	** A pascal equals 1000 New	ton per square meter	
Stress or pressure kip/sq. inch (ksi)	megapascal (Mpa)	6.894757 70.31	** A pascal equals 1000 New The prefixes and symbols	ton per square meter below are commo	nly used to form
Stress or pressure	kilogram/square	70.31	** A pascal equals 1000 New The prefixes and symbols	ton per square meter below are commo	nly used to form
Stress or pressure kip/sq. inch (ksi) kip/sq. inch (ksi)	kilogram/square centimeter (kg/sq. cm)	70.31	** A pascal equals 1000 New	ton per square meter below are commo	nly used to form
Stress or pressure kip/sq. inch (ksi)	kilogram/square centimeter (kg/sq. cm) kilogram/square centimeter (kg/sq. cm)	70.31 0.07031	** A pascal equals 1000 New The prefixes and symbols names and symbols of the of the SI units.	ton per square meter below are commo decimal multiples	nly used to form and submultiple
Stress or pressure kip/sq. inch (ksi) kip/sq. inch (ksi) pound/sq. inch (psi) pound/sq. inch (psi)	kilogram/square centimeter (kg/sq. cm) kilogram/square centimeter (kg/sq. cm) pascal (Pa) **	70.31 0.07031 6,894.757	** A pascal equals 1000 New The prefixes and symbols names and symbols of the	ton per square meter below are commo	nly used to form
Stress or pressure kip/sq. inch (ksi) kip/sq. inch (ksi) pound/sq. inch (psi) pound/sq. inch (psi) pound/sq. inch (psi)	kilogram/square centimeter (kg/sq. cm) kilogram/square centimeter (kg/sq. cm) pascal (Pa) ** megapascal (Mpa)	70.31 0.07031 6,894.757 0.00689476	** A pascal equals 1000 New The prefixes and symbols names and symbols of the of the SI units. Multiplication Factor	below are commo decimal multiples	nly used to form and submultiple Symbol
Stress or pressure kip/sq. inch (ksi) kip/sq. inch (ksi) pound/sq. inch (psi) pound/sq. inch (psi)	kilogram/square centimeter (kg/sq. cm) kilogram/square centimeter (kg/sq. cm) pascal (Pa) ** megapascal (Mpa) kilogram/square	70.31 0.07031 6,894.757	** A pascal equals 1000 New The prefixes and symbols names and symbols of the of the SI units. Multiplication Factor 1,000,000,000 = 109	ton per square meter below are commo decimal multiples Prefix giga	nly used to form and submultiple Symbol G
Stress or pressure kip/sq. inch (ksi) kip/sq. inch (ksi) pound/sq. inch (psi) pound/sq. inch (psi) pound/sq. inch (psi) pound/sq. foot (psf)	kilogram/square centimeter (kg/sq. cm) kilogram/square centimeter (kg/sq. cm) pascal (Pa) ** megapascal (Mpa) kilogram/square meter (kg/sq. m)	70.31 0.07031 6,894.757 0.00689476 4.8824	** A pascal equals 1000 New The prefixes and symbols names and symbols of the of the SI units.	below are commo decimal multiples Prefix giga mega	nly used to form and submultiple Symbol G M
Stress or pressure kip/sq. inch (ksi) kip/sq. inch (ksi) pound/sq. inch (psi) pound/sq. inch (psi) pound/sq. inch (psi)	kilogram/square centimeter (kg/sq. cm) kilogram/square centimeter (kg/sq. cm) pascal (Pa) ** megapascal (Mpa) kilogram/square	70.31 0.07031 6,894.757 0.00689476	** A pascal equals 1000 New The prefixes and symbols names and symbols of the of the SI units. Multiplication Factor 1,000,000,000 = 10 ⁹ 1,000,000 = 10 ⁶ 1,000 = 10 ³	below are commo decimal multiples Prefix giga mega kilo	nly used to form and submultiple Symbol G M k
Stress or pressure kip/sq. inch (ksi) kip/sq. inch (ksi) pound/sq. inch (psi) pound/sq. inch (psi) pound/sq. inch (psi) pound/sq. foot (psf)	kilogram/square centimeter (kg/sq. cm) kilogram/square centimeter (kg/sq. cm) pascal (Pa) ** megapascal (Mpa) kilogram/square meter (kg/sq. m)	70.31 0.07031 6,894.757 0.00689476 4.8824	** A pascal equals 1000 New The prefixes and symbols names and symbols of the of the SI units.	below are commo decimal multiples Prefix giga mega kilo centi	nly used to form and submultiple Symbol G M k c
Stress or pressure kip/sq. inch (ksi) kip/sq. inch (ksi) pound/sq. inch (psi) pound/sq. inch (psi) pound/sq. inch (psi) pound/sq. foot (psf)	kilogram/square centimeter (kg/sq. cm) kilogram/square centimeter (kg/sq. cm) pascal (Pa) ** megapascal (Mpa) kilogram/square meter (kg/sq. m)	70.31 0.07031 6,894.757 0.00689476 4.8824	** A pascal equals 1000 New The prefixes and symbols names and symbols of the of the SI units. Multiplication Factor 1,000,000,000 = 10 ⁹ 1,000,000 = 10 ⁶ 1,000 = 10 ³ 0.01 = 10 ⁻² 0.001 = 10 ⁻³	below are commo decimal multiples Prefix giga mega kilo centi milli	nly used to form and submultiple Symbol G M k c m
Stress or pressure kip/sq. inch (ksi) kip/sq. inch (ksi) pound/sq. inch (psi) pound/sq. inch (psi) pound/sq. inch (psi) pound/sq. foot (psf)	kilogram/square centimeter (kg/sq. cm) kilogram/square centimeter (kg/sq. cm) pascal (Pa) ** megapascal (Mpa) kilogram/square meter (kg/sq. m)	70.31 0.07031 6,894.757 0.00689476 4.8824	** A pascal equals 1000 New The prefixes and symbols names and symbols of the of the SI units.	below are commo decimal multiples Prefix giga mega kilo centi	nly used to form and submultiple Symbol G M k c



June 16, 1999

Mr. Ken Vought USS/POSCO 900 Loveridge Road Pittsburg, CA 94565

Dear Ken:

Attached please find two copies of the final report titled "Structural Evaluation of Steelworks' SteelJoist". We have now completed the deliverables for this project.

This has been a very active and successful project and I would like to especially thank you for your continued interest and guidance. This letter serves as our notice of final completion of the job.

The NAHB Research Center is available to assist or work with USS/POSCO to develop efficient and cost effective solutions for cold-formed steel framing and to increase steel framing market share, especially in the residential and light commercial construction markets. I am looking forward to more successful projects in the near future. Meanwhile, if you have any questions, or if I can be of further assistance, please do not hesitate to contact me directly at (800) 638-8556 ext. 581.

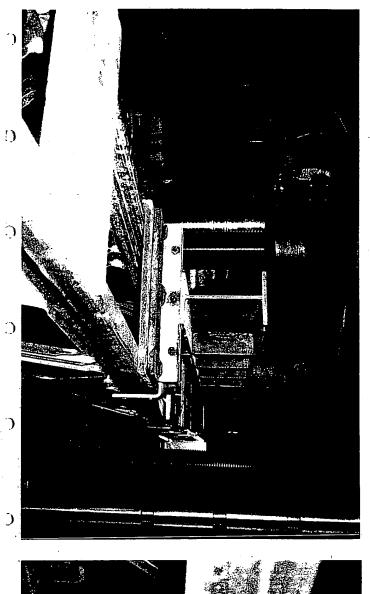
Sincerely,

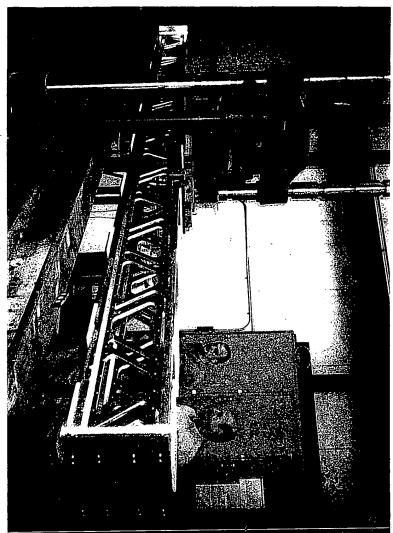
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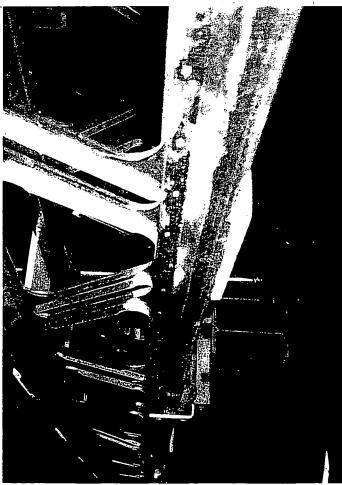
Project Manager

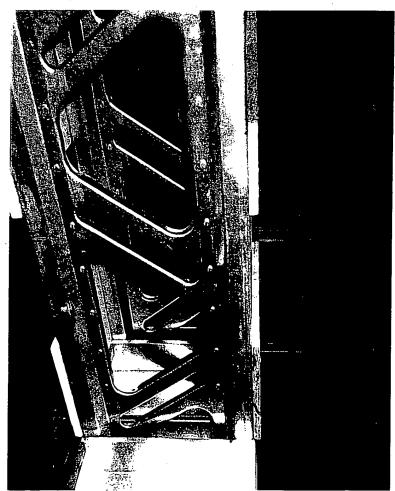
cc: Darrell Meyer (SteelWorks)

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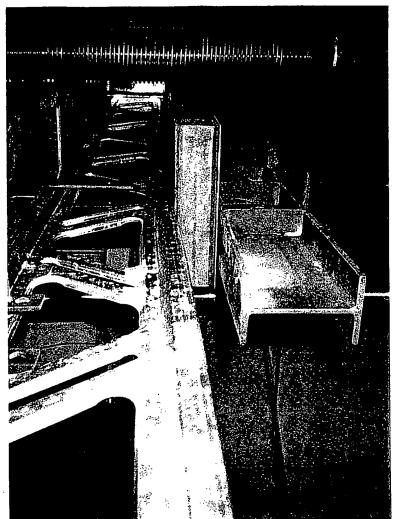


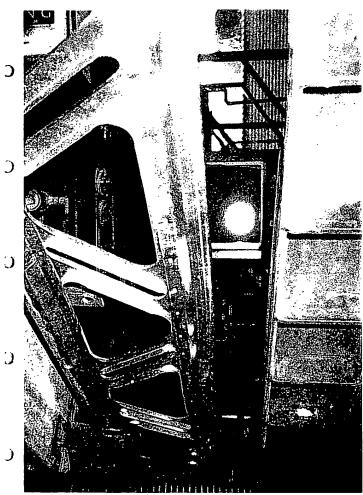






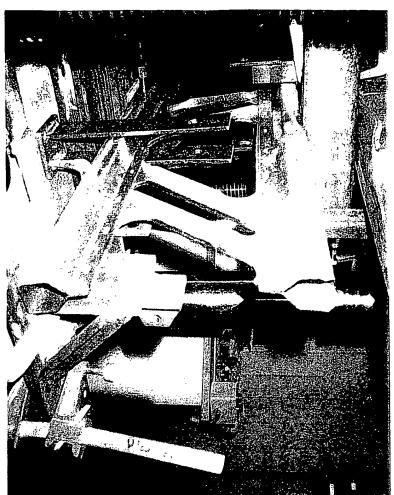


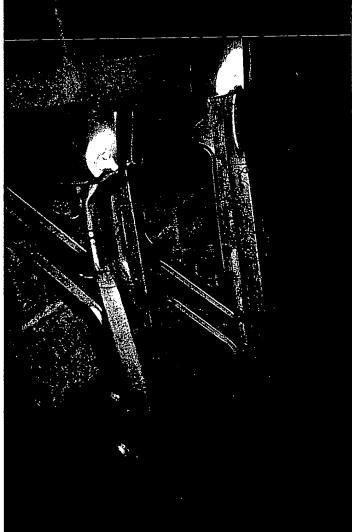








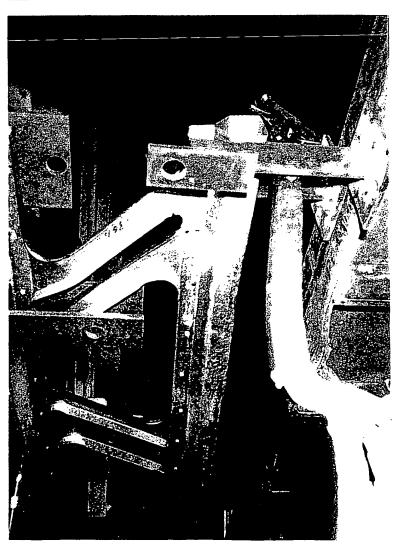


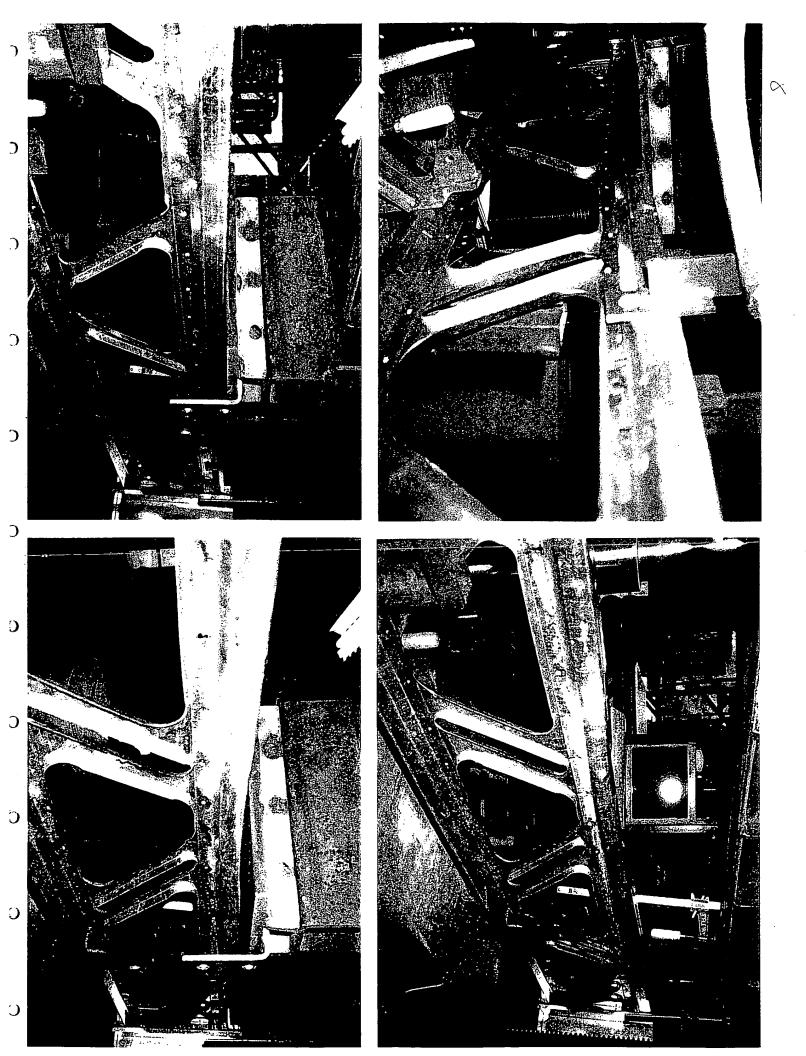


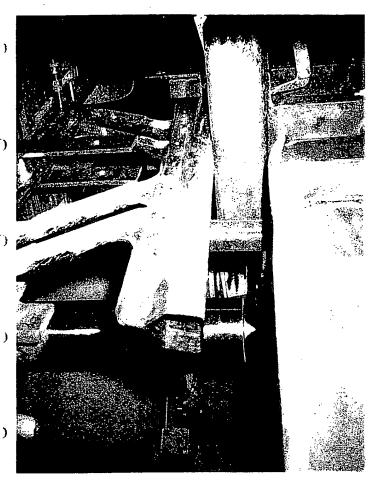
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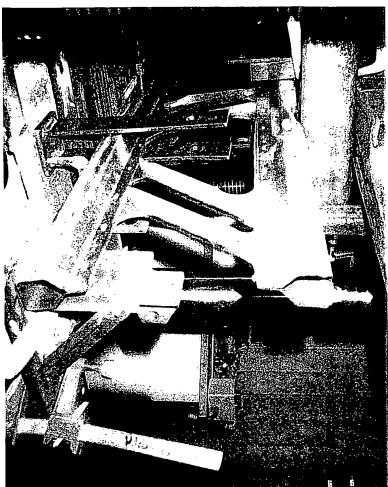
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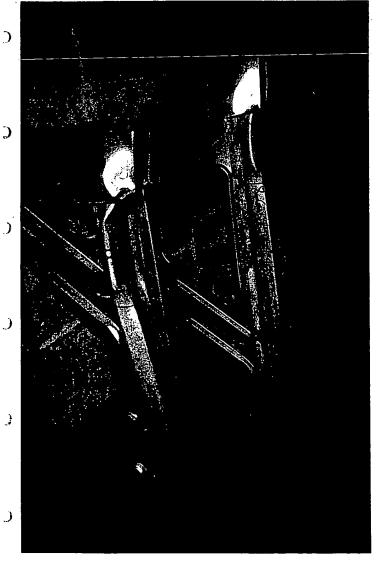
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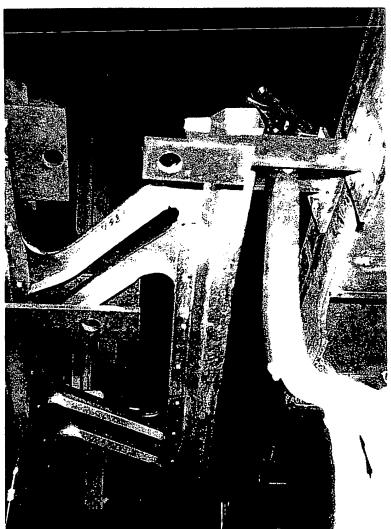














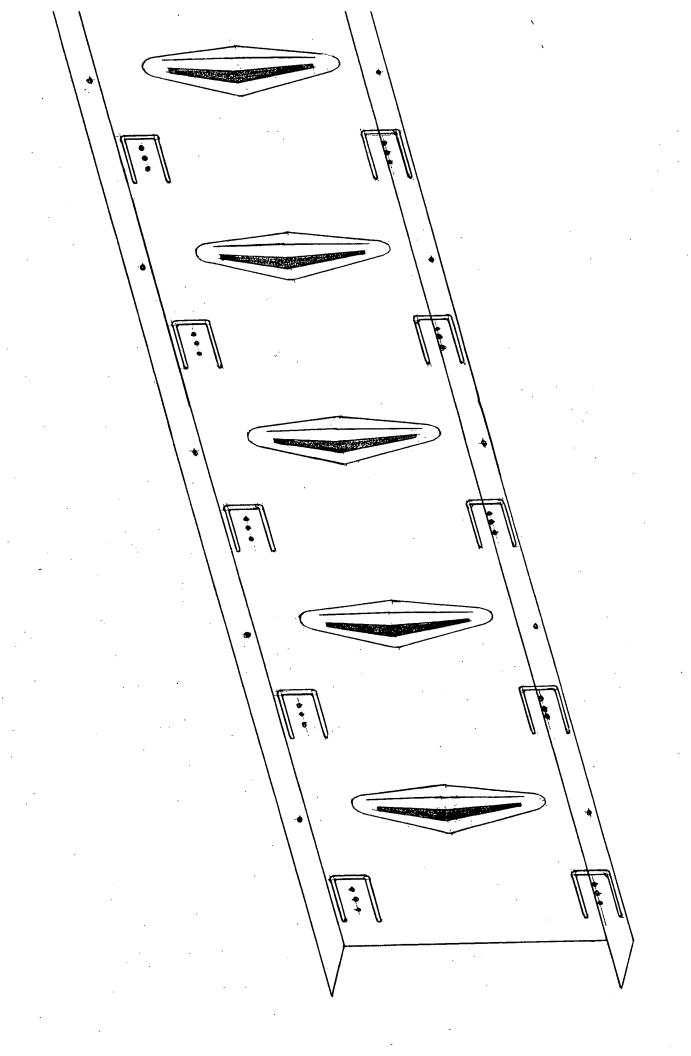






NAVIB REPARED EENTED

400 Pitnee George's Boulevind Upper Medboro, Menylend 20774-3731 301-249-4000 fee: 301-249-080s http://www.nahbuc.org exhebit 42



Oxhibit 43

BOB FISH TOES 7-30-96

TO PTION TO PURCHASE RIGHTS - SEPARATE

O, TRUSS TOIST 75,000 + 104 & FT

b. ROOF TRUSS CHORD 100,000 1038 FT

GUS TRUSS

P) DO I REMAIN INDED WOANT / INDIVIOUSE?

RESIDENCE - * ISTATE - (NEV OR PAL)

3) R & D CO.

a. They PROVIDE CAPITOL

b. IRETAIN-P. RIGHTS? OWN BY CO?

C. OPTION TO BUY BACK COMTANY?

d.

ABSTRACT

BACKGROUND OF THE /NUENTION

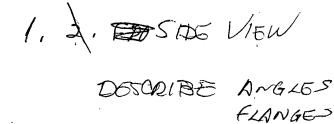
SUMMARY OF INVENTION

DESCRIPTION DE TORONIONES

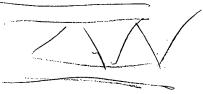
DETAILED DESCRIPTION

DESCRIPTION DE DANNINGS

2, J. END VIEW AGURS 1







3, PERSPECTIVE

4, END CAP A PUN

B WITH FLANGES - BOT

5. AM JOIST - 12" TRACK

6, PLAT SHEAR -14" SNEET

. .

mere

CLOSS KICATION DEFINITIONS

52.66

223.8

BEAM, GIRDER, ORTRUSS CONSTRUCTION!

PREZONDED STRUCTURE UNDER SUB-CLASS 223.1
WHICH IS A DISTINCT GENERALLY NORIZONIAL
STRUCTURAL MEMBER STRONGTHENED ALONG A
MAJOR OR MINOR ALLS TO COUNTERACT
FORCES FROM ADDITIONAL LANDS (E.G. FLOOR, POOF

52-104

223, 9 COMPOSED OF BUTTING SECTIONS!

BEAM, GIRDER OR TRUSS UNDER SUBCLASS 228 WHICH IS MADE UP OF A PLUBALITY OF PREFORMED SECTIONS.

5265 223.12

HOMOGENOUS DESIGN (E.G. RLL METAL)

REAM, GIRDER AR TRUSS UNDER SUBCLASS 253.,

IN WHICH THE STANCTURAL FLENOUT /NOLUDING

THE PRESTRESSING MEANS IS FABRICATED FROM.

A SINGLE MATERIAL (E.G., STEEL)

52-126 634

STOUGHTONE UNDER SUPPLIASS 633 IN WHICH THE
ELONGATED RIGID STOUGHTONE IND PRATS AUTING
AS ELONGATED RUNNERS (CHORTOS) AND CROSS
MEMBERS (STOUTS) WITH THE STOUTS BONG
IN TEGROL WITH A CHORTO.

V PRINT-OUT OF PATENT NOS.

I BEAM STAVETURE VADER SUBOLARS 720.1 JARLUDING AT LEAST 2 FLANGE MEMBERS JOINED BY A WEB MEMBER, altille FRONDE / CROSS -SECCION OF THE SHAFT IN THE SHAPE OF AN I OR H

CLASS 52 STATIC STRUCTURES (E.G. BUILDINGS CLASSIFICATION DEFINITIO. BEAM, GIRDER OR TRUES CONSTRUCTION J23.8 BEAM 7290/ 729,3 PORRUGATED WES 740.8 WOODS COMPONEUR FOLDED SWEET MATERIAL X TRUSS WITH UNITARY CHORD & WEB 634 E.G. SHEET METAL * CONTINUOUS SERPEUTING! E.G. WHOREN TRUSS 694

TRUSS WITH IN THRY CHORD CLUSTB 634
WERB PORTIONS DONNECTED BETWEEN CHORDS 636
BEAM E G. GIRDER, JOIST, ETCL 650, 1

NOMOBENOUS DESIGN (EG ALL METAL) 223,12 YES
BEAM, GIRDER OTZ TRUSS CONSTRUCTION 223,8 YES

JOIST

JOISTER

A JOIST IS A WORLDONTAL STOUCHEAL MEMBER
TO SUPPORT A FLOOR OR A ROOF.

CONVENTIONAL WOOD FRAME POWERULION UTILIZES
SOLID SKWN LUMBER, I.E. 2"X8" TO 2"X19"
IN SIZE. THESE MENTBERS ARE TYPILALLY AVAILABLE
UP TO 20 FT, LENGTHS, ARE HEAVY, ALLOW ONLY
MINOR DRILLING FOR ELECTRICAL AND QUALITY IS
DIMENINISHING DUE LACK OF OLD GROWTH TIMBER

FRERILATED WOOD JOISTS MILEDT. J. I.S (TRUSS JOIST I REAM) ARE MANUFACTURED UTILIZING SOLID OR LAMINATED TOP & BOTTOM CHORDS AND AN INTERMEDIATE SHEET OF PLYWOOD, GLUED BETWEEN THEM, AS A WEB. THESE ARE AVAILABLE IN LONG LENGTHS, VARIOUS HEIGHTS AND ARE A POPULAR CHOICE. THEY ARE LIMITED IN CERTAIN APPLICATIONS AS THEY MAY NOT BE DRILLED OR NOTCHED NEAR THEIR ENDS

FABRICATED OPEN WEB JOISTS ARE MANUFACTURED UTILIZING SOLID OR LAMINATED DOP AND BOTTOM CHOPDS LAND EIGHER WOOD OR METAL WEBS.

CLASS / SUBCLASS CLASS 52 STATIC STRUTUMES Class : 52/634 (E.G. BUILDINGS) 571000 5463837 Metal roof truss / 52/639 52/92.2 <u>52/634</u> 52/690 52/731.9 4869040-FRAMING SYSTEM 52/633 <u>52/634</u> Wall system and metal stud therefor 4793113 52/481.1 <u>52/634</u> 52/636 52/733.2 D25/119 D25/132 4490958 SHEET METAL BEAM <u>52/634</u> 52/729.3 52/729.5 52/731.7 4385476-WEB STIFFENER FOR LIGHT-GAUGE METAL FRAMING MEMBERS 52/739.1 <u>52/634</u> 4329824 SHEET METAL BEAM <u>52/634</u> 52/729.3 52/731.7 52/737.6 1228631 HOLLOW RECTANGULAR JOIST 52/690 <u>52/634</u> 52/693 52/730.7 4030256 BUILDING CONSTRUCTION 52/93.1 <u>52/634</u> 52/643 52/694 D25/61 D25/132 STEEL JOIST OR COMPOSITE STEEL AND CONCRETE CONSTRUCTION 3845594 52/98 52/334 <u>52/634</u> 52/690 52/729.<u>5</u> 3785108 ROOF TRUSSES 52/645/<u>52/634</u> 52/640 52/641 52/650.2 SUB-CUSS 634 PRINTED COPIES OF REALTED PATENTS - COMPLETE NOT RELEVANTE

4,435,940 (ANGELES) 3/1984 DAVENPORT ET AL